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## **ZEOLITE-CONTAINING CEMENT COMPOSITION**

### **Cross-Reference to Related Applications**

[0001] This application is a continuation-in-part of a prior application filed July 17, 2003 by Luke et al., which is entitled Zeolite-Containing Treating Fluid, and identified as Attorney Docket No. HES 2000-IP-002115U1P1, the entire disclosure of which is incorporated herein by reference, which is a continuation-in-part of prior Application No. 10/315,415, filed December 10, 2002, the entire disclosure of which is incorporated herein by reference.

### **Background**

[0002] The present embodiment relates generally to methods and cement compositions for sealing a subterranean zone penetrated by a wellbore.

[0003] In the drilling and completion of an oil or gas well, a cement composition is often introduced in the wellbore for cementing pipe string or casing. When the desired drilling depth of the well is reached, a cement composition is pumped into the annular space between the walls of the wellbore and the casing. In this process, known as "primary cementing", the cement composition sets in the annular space, supporting and positioning the casing, and forming a substantially impermeable barrier, or cement sheath, which isolates the wellbore from subterranean zones. It is understood that the performance of the cement composition is

important to achieving and maintaining zonal isolation. Throughout the life of a well, especially if zonal isolation is comprised, secondary cementing operations, such as remedial cementing and repairs to existing cemented areas, will be performed on the well.

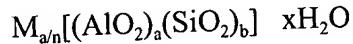
#### Description

[0100] A method of sealing a subterranean zone penetrated by a wellbore according to the present embodiments comprises preparing a cement mix comprising a base blend comprising zeolite and at least one cementitious material, mixing the cement mix with water to form a cement composition, placing the cement composition into the subterranean zone, and allowing the cement composition to set therein. A cement composition for sealing a subterranean zone penetrated by a wellbore according to the present embodiments comprises zeolite, at least one cementitious material, and a mixing fluid. In a preferred method of sealing a subterranean zone penetrated by a wellbore, a cement composition comprising zeolite, cementitious material, and water is prepared, placed into the subterranean zone, and allowed to set therein.

[0004] A variety of cementitious materials can be used with the present embodiments, including but not limited to hydraulic cements. Hydraulic cements set and harden by reaction with water, and are typically comprised of calcium, aluminum, silicon, oxygen, and/or sulfur. Hydraulic cements include Portland cements, pozzolan cements, gypsum cements, aluminous cements, silica cements, and alkaline cements. According to preferred embodiments, the cementitious material comprises at least one API Portland cement. As used herein, the term API Portland cement means any cements of the type defined and described in API Specification 10, 5<sup>th</sup> Edition, July 1, 1990, of the American Petroleum Institute (the entire disclosure of which is hereby incorporated as if reproduced in its entirety), which includes Classes A, B, C, G, and H. According to certain embodiments disclosed herein, the cementitious material comprises any of Classes A, C, G and H cement. The preferred amount of cementitious material is understandably dependent on the cementing operation.

[0005] Zeolites are porous alumino-silicate minerals that may be either a natural or manmade material. Manmade zeolites are based on the same type of structural cell as natural zeolites and

are composed of aluminosilicate hydrates having the same basic formula as given below. It is understood that as used in this application, the term "zeolite" means and encompasses all natural and manmade forms of zeolites. All zeolites are composed of a three-dimensional framework of  $\text{SiO}_4$  and  $\text{AlO}_4$  in a tetrahedron, which creates a very high surface area. Cations and water molecules are entrained into the framework. Thus, all zeolites may be represented by the crystallographic unit cell formula:



where M represents one or more cations such as Na, K, Mg, Ca, Sr, Li or Ba for natural zeolites and  $\text{NH}_4$ ,  $\text{CH}_3\text{NH}_3$ ,  $(\text{CH}_3)_3\text{NH}$ ,  $(\text{CH}_3)_4\text{N}$ , Ga, Ge and P for manmade zeolites; n represents the cation valence; the ratio of b:a is in a range of from greater than or equal to 1 to less than or equal to 5; and x represents the moles of water entrained into the zeolite framework.

**[0006]** Preferred zeolites for use in the cement compositions of the present embodiments include analcime (hydrated sodium aluminum silicate), bikitaite (lithium aluminum silicate), brewsterite (hydrated strontium barium calcium aluminum silicate), chabazite (hydrated calcium aluminum silicate), clinoptilolite (hydrated sodium aluminum silicate), faujasite (hydrated sodium potassium calcium magnesium aluminum silicate), harmotome (hydrated barium aluminum silicate), heulandite (hydrated sodium calcium aluminum silicate), laumontite (hydrated calcium aluminum silicate), mesolite (hydrated sodium calcium aluminum silicate), natrolite (hydrated sodium aluminum silicate), paulingite (hydrated potassium sodium calcium barium aluminum silicate), phillipsite (hydrated potassium sodium calcium aluminum silicate), scolecite (hydrated calcium aluminum silicate), stellerite (hydrated calcium aluminum silicate), stilbite (hydrated sodium calcium aluminum silicate) and thomsonite (hydrated sodium calcium aluminum silicate). Most preferably, the zeolite for use in the cement compositions of the present invention comprises one of chabazite and clinoptilolite.

**[0007]** As shown in the following examples, zeolites provide enhanced properties in a number of embodiments of cement compositions. For example, according to some embodiments, cement compositions comprising zeolite exhibit an increase in early compressive

strength development at low temperatures. In other embodiments, cement compositions comprising zeolite exhibit thixotropic properties which can be of benefit in such applications as gas migration control, lost circulation and squeeze cementing. According to still other embodiments, cement compositions comprising zeolite have fluid loss control qualities that enable maintenance of a consistent fluid volume within the cement composition, and prevent formation fracture (lost circulation) or flash set (dehydration).

**[0008]** In one embodiment, a cement mix comprises zeolite mixed with a base blend comprising 100% by weight cementitious material. In another embodiment, a cement mix comprises a base blend comprising zeolite in an amount of from about 5 to about 75 weight percent. In another embodiment, a cement mix comprises a base blend comprising zeolite in an amount of from about 30 to about 90 weight percent, and more preferably in an amount of from about 50 to about 75 weight percent. The preferred amount of zeolite is understandably dependent on the application for the cement composition. Exemplary applications are discussed further in the Examples herein.

**[0010]** Without limiting the scope of the invention, it is understood that the above-described cement compositions comprising zeolite have various applications, including but not limited to (1) lightweight cements; (2) normal weight cements; (3) densified cements; (4) squeeze cements; and (5) foamed cements. While there are no standard values with respect to the densities of the foregoing compositions, the term lightweight cement is understood by those of skill in the art to describe a cement composition having a density of less than about 15 lb/gal, the term normal weight cement is understood by those of skill in the art to describe a cement composition having a density of greater than about 15 lb/gal, but less than about 16 lb/gal, the term densified cement is understood by those of skill in the art to describe a cement composition having a density greater than about 16 lb/gal, and squeeze cements are understood by those of skill in the art to be cements of any density from densified to lightweight, depending on the application. For the purpose of the present disclosure, the terms “lightweight”, “normal”, “densified”, and “squeeze” shall have the foregoing meanings as would be understood by one of ordinary skill in the art.

[0011] According to some embodiments, the cement mix comprises a base blend comprising zeolite and at least one cementitious material. According to other embodiments, the cement mix comprises zeolite mixed with a base blend comprising 100% by weight of at least one cementitious material. A variety of additives may be added into either of the above-described embodiments (i.e., a cement mix comprising a base blend comprising zeolite, or a cement mix comprising a base blend comprising 100% cementitious material.) When present, the additives comprise components of the cement mix in addition to the base blend.

[0012] Additives alter physical properties of cement compositions. Such additives may include density modifying materials (e.g., silica flour, sodium silicate, microfine sand, iron oxides and manganese oxides), dispersing agents, set retarding agents, set accelerating agents, fluid loss control agents, strength retrogression control agents, and viscosifying agents, all of which are well known to those of ordinary skill in the art.

[0013] For example, according to one embodiment, conventional accelerating additives such as sodium chloride, sodium sulfate, sodium aluminate, sodium carbonate, calcium sulfate, calcium carbonate, aluminum sulfate, potassium sulfate, potassium carbonate and alums, any of which can be used alone or in combination with other accelerating additives, are added to the cement mixes from which cement compositions are formed to further increase early compressive strength development. The accelerating additives are present in a total amount of about 0.5% to about 12% based on the total weight of the base blend comprising the cement mix, and more preferably, in a total amount of about 3% to about 9% based on the total weight of the base blend comprising the cement mix.

[0014] According to other embodiments, fluid loss control additives comprising anionic or non-ionic water based soluble polymers are added to a cement mix containing zeolite to provide effective fluid loss control for cement compositions formed from such cement mixes. According to these embodiments, the anionic or non-ionic water based soluble polymers may or may not be hydrophobically modified.

[0015] According to other embodiments, zeolite is used as a suspending aid, thixotropic agent, particle packing agent, strength retrogression prevention agent, strength enhancer, foamed cement-stability agent, a low temperature accelerator, a flow enhancing agent, a lightweight material and a friction reducer. For example, according to one such embodiment, a cement mix is formed by dry-mixing zeolite with cementitious material to form a base blend where the zeolite functions as a flow enhancing agent. According to this embodiment, the base blend comprises from about 1 to about 35 weight percent zeolite. Furthermore, conventional flow enhancing agents may be adsorbed on the zeolite to further enhance flow properties. Conventional flow enhancing agents are polar molecules known to those of ordinary skill in the art, and include but are not limited to organic acids, their salts, and acid anhydrides. A preferred conventional flow enhancing agent is acetic acid.

[0016] According to yet another embodiment, a lightweight cement composition is formed from a cement mix comprising a base blend comprising at least one cementitious material and zeolite, where the zeolite is present in an amount of about 35 to about 50 weight percent. The cement mix can then be added to a mixing fluid to form a lightweight cement composition. Conventionally, lightweight cement compositions are made by adding lightweight materials such as hollow microspheres, perlite and gilsonite to the cement mix for a given cement composition. These lightweight materials are dry blended with the cement mix, transported to a location, and mixed with water to form a cement composition. During blending and transportation, the lightweight materials tend to segregate from the rest of the cement mix due to their size and specific gravity differences with respect to the rest of the cement mix. In addition, depending on the density of the cement compositions formed from a cement mix, a high volume of the lightweight material may be present, which can cause additional segregation. The high volume also requires more mix water to form a slurry from the cement mix, which results in a reduction of the compressive strength obtained for the set cement resulting from the slurry. Using zeolites to form the base blend of a cement mix results in a reduction in segregation, a reduction in the amount of water required to form a slurry, and a lightweight cement composition with good compressive strength. In addition, a range of lightweight cement compositions can be produced

from a single cement mix comprising zeolite by merely changing the amount of mixing fluid added to an amount of the cement mix to form a cement composition.

[0017] According to yet another embodiment, a cement mix is formed from a base blend comprising micro-fine zeolites. As used herein, micro-fine zeolites are zeolites with a mean particle size of about 10.00 microns or less. Cement compositions formed from cement mixes comprising such micro-fine zeolites possess early compressive strength development, provide good suspension (also referred to as “anti-settling”) properties and are stable when formed as lightweight cement compositions. Cement compositions comprising micro-fine zeolites are useful in all cement applications, and are particularly useful in secondary cementing applications, for example, repairing microannuli, voids, and channels in the cement sheath.

[0018] According to yet another embodiment, a cement mix is formed comprising a base blend comprising zeolite, where the zeolite is incorporated into the base blend of the cement mix to act as a dispersant. According to this embodiment, when a zeolite is incorporated into the base blend of a cement mix, the zeolite reduces the apparent viscosity of cement compositions subsequently formed from the cement mix. Moreover, conventional dispersants such as sulfonated polymers including napthalene sulfonate, melamine sulfonate, styrene sulfonate, phenol sulfonate and ketone sulfonate can also be used in zeolite-containing cement mixes to reduce apparent viscosity. Furthermore, such conventional dispersants may be added to control fluid loss. An example of such conventional dispersant is sulfonated ketone acyclic aldehyde condensate available from Halliburton Energy Services, Duncan, Oklahoma. When used, such conventional dispersants are generally present in a range from about 0.01% to about 2% by weight of the base blend of a cement mix.

[0019] According to yet another embodiment, zeolites are incorporated into a cement composition as an aqueous suspension, referred to herein as “aqueous zeolite suspensions” rather than as dry materials in a dry-mixed base blend. According to yet another embodiment, stable liquid additives comprising aqueous zeolite suspensions are prepared. Preferably, the aqueous

zeolite suspension comprises from about 40 to about 60 weight percent zeolite. According to one embodiment, the zeolite used to prepare the aqueous suspensions comprises chabazite.

**[0020]** According to embodiments where the zeolite is provided as an aqueous suspension, the aqueous zeolite suspension enhances rheological and compressive strength properties similar to the enhancement that occurs when zeolite is dry-mixed into a base blend as described for other embodiments disclosed herein. Moreover, aqueous zeolite suspensions provide certain convenience, logistical and economic benefits compared to dry-blended zeolite compositions, making such aqueous zeolite suspensions preferable for some cementing applications.

**[0021]** According to yet another embodiment, aqueous zeolite suspensions may be used as a carrier for lightweight materials, such as hollow microspheres, gilsonite and perlite. Such lightweight materials typically have a specific gravity of 1.0 and less. In current cementing applications, lightweight materials may be dry-blended with cement and cement additives and then transported to location, where they are mixed with mixing fluids (such as water) to form low density cement compositions, typically having a density of 11.0 lb/gal or less. During blending and transportation, however, the lightweight additives tend to segregate from the rest of the dry-blend, in part due to their lower specific gravity with respect to the rest of the dry-blend. Segregation of the lightweight materials has adverse consequences for cement compositions being formed from that dry-blend. However, when the lightweight materials are added to an aqueous zeolite suspension to form a homogenous mixture, the aqueous zeolite suspension keeps the lightweight material in suspension. The aqueous zeolite-lightweight material suspension can be prepared at the location where the cementing application is to occur, or it can be transported to such a location without the risk of segregation of the lightweight materials during transport.

**[0022]** According to yet another embodiment, zeolite is incorporated into the base blend of cement mix from which a foam cement composition is prepared. The zeolite acts as a foam cement-stability agent. Conventional foam cements must be stabilized to keep gas entrained within the system. A conventional method for stabilizing foam cements is to add viscosifiers such as gel or microfine particles. According to this embodiment, a foam cement composition is

prepared from a cement mix comprising a base blend comprising from about 1 to about 25 weight percent zeolite. The zeolite is effective in stabilizing foam cement compositions made from such cement mix.

[0023] According to yet another embodiment, zeolites are used to make low density foamed cement compositions. In order for conventional foam cements to achieve high compressive strengths, the base system (the unfoamed cement) must have a high compressive strength. Typically, this means that the base system has to be slightly densified. The higher density of the base system requires a higher foam quality (more air per volume of base system) in order to achieve the desired lower density for the foamed cement. However, the higher foam quality results in an increase in the permeability of the cement composition once it has set. According to this embodiment, incorporation of zeolite into the base system, where the zeolite is dry-mixed with the cement mix or is incorporated as an aqueous suspension, enables the use of a lower foam quality (less air per volume of base system) to produce lower density foamed cement. The zeolite enhances the compressive strength of the base system, and allows for a low density base system. In addition, because there is less air in the foamed cement composition, the permeability of the set cement is reduced.

[0024] Water in the cement compositions according to the present embodiments is present in an amount sufficient to make a slurry of the desired density from the cement mix, and that is pumpable for introduction down hole. The water used to form a slurry can be fresh water, unsaturated salt solution, including brines and seawater, and saturated salt solution. Generally, any type of water can be used, provided that it does not contain an excess of compounds that are well known to those skilled in the art to adversely affect properties of the cement composition. The water is present in an amount of about 22% to about 200% by weight of the base blend comprising a cement mix, and more preferably in an amount of about 40% to about 150% by weight of the base blend comprising a cement mix.

[0025] In carrying out methods of the present embodiment, a subterranean zone penetrated by a wellbore is sealed by placing a cement composition comprising zeolite, cementitious

material and water into the subterranean zone and allowing the cement composition to set therein. Also, in carrying out the methods of the present embodiment, a cement composition of the present embodiment is prepared by mixing a cement mix comprising a base blend comprising zeolite and at least one cementitious material with a mixing fluid. The cement composition is then placed into a subterranean zone and allowed to set therein. In carrying out the methods of the present embodiment, a base blend comprising zeolite is prepared by mixing zeolite with at least one cementitious material. A base blend prepared according to the present embodiment is then used to form a cement composition in accordance with methods of the present embodiment.

**[0026]** In carrying out other methods of the present embodiment, a cement mix is prepared by mixing a base blend comprising at least one cementitious material with zeolite. The cement mix is mixed with a mixing fluid to form a cement composition according to the present embodiment, which is then placed into the subterranean zone and allowed to set therein, thus sealing the subterranean zone. In carrying out still other methods of the present embodiment, a cement mix is formed from a base blend comprising 100 weight percent of at least one cementitious material, and zeolite is mixed with the base blend as an additive.

**[0027]** According to still other methods of the present embodiment, a subterranean zone penetrated by a wellbore is sealed by placing a cement composition prepared with an aqueous zeolite suspension into the subterranean zone and allowing the cement composition to set therein. In carrying out methods of the present embodiment, a cement mix comprising a base blend is blended with an aqueous zeolite suspension to form a cement composition of the present embodiment. According to still other methods of the present embodiment, an aqueous zeolite suspension is prepared by mixing zeolite with a mixing fluid, and adding at least one lightweight material thereto. According to still other methods, a cement composition having a density less than about 12 lb/gal is prepared by blending an aqueous zeolite suspension comprising zeolite and at least one lightweight material with a cement mix.

**[0028]** According to still other methods of the present embodiment, a subterranean zone penetrated by a wellbore is sealed by placing a foamed cement composition according to the

present embodiment into the subterranean zone and allowing the foamed cement composition to set therein. A foamed cement composition according to the present embodiment is prepared by foaming an unfoamed cement composition comprising zeolite.

[0029] In carrying out methods of the present embodiment, an unfoamed cement composition is prepared by mixing a cement mix comprising a base blend comprising zeolite and at least one cementitious material with a mixing fluid. According to other methods of the present embodiment, an aqueous zeolite suspension is mixed with the unfoamed cement composition formed from a base blend that may or may not comprise zeolite. According to still other methods, the foamed cement composition formed from an unfoamed cement composition is stabilized by one or more of zeolite in an aqueous zeolite suspension mixed with the unfoamed cement composition, or zeolite in the base blend of the unfoamed cement composition.

[0030] The zeolite used in carrying out any of the foregoing methods of the present embodiment can be as previously described herein. In preferred embodiments, the zeolite is selected from the group consisting of analcime, bikitaite, brewsterite, chabazite, clinoptilolite, faujasite, harmotome, heulandite, laumontite, mesolite, natrolite, paulingite, phillipsite, scolecite, stellerite, stilbite, and thomsonite. Also, according to methods of the present embodiment, the zeolite used can be of a desirable particle size, for example, about 100 microns or less, or from about 3 microns to about 15 microns.

[0031] Also, according to any of the foregoing methods of the present embodiment, cement compositions, cement mixes and base blends are prepared that comprise additives known to those of ordinary skill in the art, including but not limited to fly ash, silica, lightweight additives, accelerating additives, retarders, fluid loss control additives, flow enhancing agents, and dispersants. Any such cement compositions, cement mixes, and base blends can be placed into a subterranean zone and allowed to set therein, thereby sealing the subterranean zone.

[0032] The following examples are illustrative of the methods and compositions discussed above.

## EXAMPLE 1

[0033] Components in the amounts listed in **TABLE 1** were added to form four batches of a normal density slurry. The batches were prepared according to API Specification RP 10B, 22<sup>nd</sup> Edition, 1997, of the American Petroleum Institute (the entire disclosure of which is hereby incorporated as if reproduced in its entirety).

[0034] Each batch was formed from a cement mix comprising a base blend comprising 100 weight percent Class A cement. Zeolite was added as an additive in the amount as indicated in Table 1, which is reported as a percent by weight of the base blend (% bwob). The water amounts are also reported as percentages based on the weight of the base blend. The density was conventionally measured, and reported in both metric units, kilogram per cubic meter ("kg/m<sup>3</sup>") and imperial, pounds per gallon ("lb/gal").

[0035] Zeolite was obtained from C2C Zeolite Corporation, Calgary, Canada, and mined from Bowie, Arizona, USA. The specific zeolite material used was chabazite.

**TABLE 1**

<b>Components</b>	<b>Batch 1</b>	<b>Batch 2</b>	<b>Batch 3</b>	<b>Batch 4</b>
Cement (%)	100	100	100	100
Zeolite (% bwob)	0	10	0	10
Water (% bwob)	46.7	56.9	46.7	56.9
Density kg/m <sup>3</sup> (lb/gal)	1872 (15.6)	1800 (15.0)	1872 (15.6)	1800 (15.0)
Compressive Strength Test Temperature °C (°F)	4 (40)	4 (40)	16 (60)	16 (60)
Compressive strength @ 12 hours: MPa (psi)	1.31 (190)	2.22 (322)	3.83 (555)	5.01 (726)
Compressive strength @ 24 hours: MPa (psi)	2.07 (300)	5.20 (753)	10.00 (1450)	10.40 (1507)
Compressive strength @ 48 hours: MPa (psi)	--	10.72 (1554)	17.25 (2500)	17.94 (2600)

[0036] The compressive strength data was determined by Non-Destructive Sonic Testing as set forth in API Specification 10B 22<sup>nd</sup> Edition, 1997, of the American Petroleum Institute, the

entire disclosure of which is hereby incorporated herein by reference. **TABLE 1** shows that batches with zeolite (Batches 2 and 4) had higher compressive strengths than conventional cement slurries (Batches 1 and 3) at the range of temperatures tested.

## **EXAMPLE 2**

[0037] Components in the amounts listed in **TABLE 2** were added to form four batches of a lightweight pozzolanic slurry. The batches were prepared according to API Specification RP 10B, 22<sup>nd</sup> Edition, 1997, of the American Petroleum Institute (the entire disclosure of which is hereby incorporated as if reproduced in its entirety).

[0038] Each batch was formed from a cement mix comprising a base blend comprising Class C cement, zeolite, fly ash and fumed silica in the amounts reported in **Table 2**, which are expressed as weight percent. Water was added to each base blend in the amount reported in **Table 2**, which is reported as a weight based on the weight of the base blend ("%" bwob"). The density was conventionally measured, and reported in both metric units, kilogram per cubic meter ("kg/m<sup>3</sup>") and imperial, pounds per gallon ("lb/gal").

[0039] Zeolite was obtained from C2C Zeolite Corporation, Calgary, Canada, and mined from Bowie, Arizona, USA. The specific zeolite material used was chabazite. Fumed silica was obtained from either Fritz Industries, Mesquite, Texas, USA, or Elkem Group, Oslo, Norway. The fly ash was Class F fly ash, commercially available from Halliburton Energy Services, Duncan, Oklahoma.

**TABLE 2**

<b>Components</b>	<b>Batch 1</b>	<b>Batch 2</b>	<b>Batch 3</b>	<b>Batch 4</b>
Cement (%)	56	56	56	56
Fly Ash (%)	22	22	22	22
Fumed silica (%)	22	0	22	0
Zeolite (%)	0	22	0	22
Water (% bwob)	110	110	110	110
<b>Properties</b>				

Density kg/m <sup>3</sup> (lb/gal)	1440 (12.0)	1440 (12.0)	1440 (12.0)	1440 (12.0)
Compressive Strength Test Temperature ° C (°F)	27 (80)	27 (80)	82 (180)	80 (180)
Compressive strength @ 12 hours: MPa (psi)	0.55 (79)	0.42 (61)	5.13 (743)	4.86 (704)
Compressive strength @ 24 hours: MPa (psi)	1.02 (148)	0.92 (133)	6.51 (944)	6.21 (900)
Compressive strength @ 48 hours: MPa (psi)	1.54 (223)	1.52 (220)	6.90 (1000)	6.35 (921)
Compressive strength @ 72 hours: MPa (psi)	2.03 (295)	2.03 (295)	6.90 (1000)	6.35 (921)
Thickening Time (hr:min)	5:20	4:03	5:43	4:15
Plastic Viscosity (cP)	41.4	49.9	16.9	18.3
Yield point (lb/100ft <sup>2</sup> )	23.6	25.3	12.3	10.3

[0040] The compressive strength data was determined by Non-Destructive Sonic Testing as set forth in API Specification 10B 22<sup>nd</sup> Edition, 1997, of the American Petroleum Institute, the entire disclosure of which is hereby incorporated herein by reference. **TABLE 2** shows that batches with zeolite (Batches 2 and 4) are an acceptable substitute for conventional fumed silica cement slurries (Batches 1 and 3).

### EXAMPLE 3

[0041] Components in the amounts listed in **TABLE 3** were added to form five batches of a lightweight microsphere slurry. The batches were prepared according to API Specification RP 10B, 22<sup>nd</sup> Edition, 1997, of the American Petroleum Institute (the entire disclosure of which is hereby incorporated as if reproduced in its entirety).

[0042] Each batch was formed from a cement mix comprising a base blend comprising 100 weight percent Class C cement. Cenospheres (hollow ceramic microspheres) were added to each cement mix in an amount of 50% bwob, where % bwob indicates a percentage based on the

weight of the base blend. Such cenospheres are available from PQ Corp., Chattanooga, Tennessee, USA. The other additives, namely the zeolite and the fumed silica in this example, as well as the water amount, are reported as percentages based on the weight of the base blend ("%" bwob"). The density was conventionally measured, and reported in both metric units, kilogram per cubic meter ("kg/m<sup>3</sup>") and imperial, pounds per gallon ("lb/gal").

[0043] Zeolite was obtained from C2C Zeolite Corporation, Calgary, Canada, and mined from Bowie, Arizona, USA. The specific zeolite material used was chabazite. Fumed silica was obtained from either Fritz Industries, Mesquite, Texas, USA, or Elkem Group, Oslo, Norway.

**TABLE 3**

	<b>Batch 1</b>	<b>Batch 2</b>	<b>Batch 3</b>	<b>Batch 4</b>	<b>Batch 5</b>
Water (% bwob)	98	98	98	98	98
Cement (%)	100	100	100	100	100
Fumed silica (% bwob)	0	0	0	15	0
Zeolite (% bwob)	0	15	0	0	15
<b>Properties</b>					
Density kg/m <sup>3</sup> (lb/gal)	1380 (11.5)	1380 (11.5)	1380 (11.5)	1380 (11.5)	1380 (11.5)
Compressive Strength Test Temperature °C (°F)	49 (120)	49 (120)	93 (200)	93 (200)	93 (200)
Compressive strength @ 24 hours: MPa (psi)	7.64 (1107)	7.66 (1110)	8.29 (1202)	15.35 (2225)	14.00 (2026)
Compressive strength @ 48 hours: MPa (psi)	11.18 (1621)	11.96 (1734)	13.39 (1940)	18.41 (2669)	15.70 (2276)
Compressive strength @ 72 hours: MPa (psi)	13.40 (1942)	13.40 (1942)	12.34 (1789)	18.81 (2726)	--
Comments	settling	no settling	settling	no settling	no settling

[0044] The compressive strength data was determined by Non-Destructive Sonic Testing as set forth in API Specification 10B 22<sup>nd</sup> Edition, 1997, of the American Petroleum Institute, the entire disclosure of which is hereby incorporated herein by reference. TABLE 3 shows that

batches with zeolite (Batches 2 and 5) did not settle, which demonstrates that zeolite performs as an anti-settling agent, and is comparable as an anti-settling agent to conventional fumed silica (Batch 4).

#### **EXAMPLE 4**

[0045] Components in the amounts listed in TABLE 4 were added to form three types of an 11.7 lb/gal density cement composition. The density was conventionally measured, and reported in both metric units, kilogram per cubic meter ("kg/m<sup>3</sup>") and imperial, pounds per gallon ("lb/gal"). The cement compositions were prepared according to API Specification RP 10B, 22<sup>nd</sup> Edition, 1997, of the American Petroleum Institute (the entire disclosure of which is hereby incorporated as if reproduced in its entirety).

[0046] Type 1 was formed from a cement mix comprising a base blend comprising 100 weight percent Class C cement. The water amount used to form the Type 1 cement composition is also reported as a percentage based on the weight of the base blend. Prehydrated bentonite in the amount as reported in Table 4 was added to the water used to form the cement composition, and is reported in Table 4 as a percentage based on the weight of the base blend ("% bwob"). Prehydrated bentonite, can be obtained under the trademark "AQUA GEL GOLD" from Halliburton Energy Services, Inc., Houston, Texas USA.

[0047] Type 2 was formed from a cement mix that comprised a base blend comprising 60 weight percent Class C cement, 5 weight percent accelerating additive (which itself is comprised of 1 weight percent sodium meta silicate; 2 weight percent sodium sulfate; 2 weight percent calcium chloride), 15 weight percent fumed silica, 1 weight percent prehydrated bentonite, and 19 weight percent fly ash. Fly ash was obtained from Ashcor Technologies, Calgary, Alberta, Canada (samples obtained at Sheerness and Battle River). Fumed silica was obtained from either Fritz Industries, Mesquite, Texas, USA, or Elkem Group, Oslo, Norway. The water amount for Type 2 is reported as a percentage based on the weight of the base blend ("% bwob") of the cement mix. As with Type 1, the prehydrated bentonite used for Type 2 was added to the water

as a percentage based on the weight of the base blend ("% bwob"). Prehydrated bentonite, can be obtained under the trademark "AQUA GEL GOLD" from Halliburton Energy Services, Inc., Houston, Texas USA.

[0048] Type 3 was formed from a cement mix that comprised a base blend comprising 60 weight percent Class C cement, 30 weight percent zeolite (mesh size 1), and 10 weight percent (mesh size 2) zeolite. The zeolite was clinoptilolite obtained from C2C Zeolite Corporation, Calgary, Canada, and was further divided by particle size, i.e., its ability to pass through conventional mesh screens sizes 1 and 2. The water amount for Type 3 is reported as a percentage based on the weight of the base blend ("% bwob") of the cement mix.

**TABLE 4**

	Type 1	Type 2	Type 3
<b>Components</b>			
Cement %	100%	60%	60%
Zeolite (mesh size 1) %	0	0	30%
Zeolite (mesh size 2) %	0	0	10%
Prehydrated bentonite	4% bwob	1%	0
Fly ash	0	19%	0
Fumed silica	0	15%	0
Accelerating additives		5%	
Water	154% bwob	114% bwob	130% bwob
<b>Properties</b>			
Density kg/m <sup>3</sup> (lb/gal)	1400 (11.7)	1400 (11.7)	1400 (11.7)
Time to 0.35 MPa (50 psi) at 20°C (68°F) (hr:min)	no set	4:43	9:21
Time to 0.35 MPa (50 psi) at 30°C (86°F) (hr:min)	no set	3:16	--
Time to 0.35 MPa (50 psi) at 40°C (104°F) (hr:min)	21:31	3:36	4:13

	Type 1	Type 2	Type 3
Time to 0.35 MPa (50 psi) at 50°C (122°F) (hr:min)	8:12	--	1:45
Time to 3.5 MPa (500 psi) at 20°C (68°F) (hr:min)	N/A	52:14	52:30
Time to 3.5 MPa (500 psi) at 30°C (86°F) (hr:min)	N/A	22:57	19:10
Time to 3.5 MPa (500 psi) at 40°C (104°F) (hr:min)	N/A	16:05	16:45
Time to 3.5 MPa (500 psi) at 50°C (122°F) (hr:min)	N/A	--	11:07

[0049] **TABLE 4** shows that the zeolite cement composition (Type 3) sets faster than the conventional bentonite cement composition (Type 1) even at low temperatures, and delivers results similar to conventional fumed silica compositions (Type 2).

#### **EXAMPLE 5**

[0050] Components in the amounts listed in **TABLE 5** were added to form five batches of an 11.7 lb/gal density cement composition. The density was conventionally measured, and reported in both metric units, kilogram per cubic meter ("kg/m<sup>3</sup>") and imperial, pounds per gallon ("lb/gal"). The batches were prepared according to API Specification RP 10B, 22<sup>nd</sup> Edition, 1997, of the American Petroleum Institute (the entire disclosure of which is hereby incorporated as if reproduced in its entirety).

[0051] Each batch was formed from a cement mix that comprised a base blend comprising 60 weight percent Class C cement, 30 weight percent zeolite (mesh size 1), and 10 weight percent (mesh size 2). The zeolite was clinoptilolite obtained from C2C Zeolite Corporation, Calgary, Canada, and was further divided by particle size, i.e., its ability to pass through conventional mesh screens sizes 1 and 2.

[0052] The accelerating additive for Batch 2 was calcium sulfate, the accelerating additive for Batch 3 was sodium aluminate, and the accelerating additive for Batches 4 and 5 was sodium sulfate. The amounts of accelerating additive are reported as percentages based on the weight of the base blend ("% bwob") of the cement mix. The water amounts for each batch are also reported as percentages based on the weight of the base blend ("% bwob") of the cement mix.

**TABLE 5**

<b>Components</b>	<b>Batch 1</b>	<b>Batch 2</b>	<b>Batch 3</b>	<b>Batch 4</b>	<b>Batch 5</b>
Cement %	60	60	60	60	60
Zeolite (mesh size 1) %	30	30	30	30	30
Zeolite (mesh size 2) %	10	10	10	10	10
Accelerating additive % bwob	0	3	3	3	6
Water % bwob	130	130	130	130	130
Density kg/m <sup>3</sup> (lb/gal)	1400 (11.7)	1400 (11.7)	1400 (11.7)	1400 (11.7)	1400 (11.7)
Temperature °C (°F)	50 (122)	50 (122)	50 (122)	50 (122)	50 (122)
Compressive strength @ 12 hours: MPa (psi)	0 (1)	2.39 (347)	1.78 (258)	1.35 (196)	2.46 (356)
Compressive strength@ 24 hours: MPa (psi)	0.72 (104)	2.45 (355)	3.66 (531)	2.48 (360)	5.14 (745)
Compressive strength@ 48 hours:MPa (psi)	2.76 (400)	5.16 (748)	6.23 (903)	4.74 (687)	5.84 (847)

[0053] TABLE 5 shows that cement compositions containing zeolite set with conventional accelerating additives, as illustrated by the increase in compressive strengths over time.

#### **EXAMPLE 6**

[0054] Components in the amounts listed in TABLE 6 were added to form five batches of a 15.6 lb/gal cement composition. The density was conventionally measured, and reported in both metric units, kilogram per cubic meter ("kg/m<sup>3</sup>") and imperial, pounds per gallon ("lb/gal"). The

batches were prepared according to API Specification RP 10B, 22<sup>nd</sup> Edition, 1997, of the American Petroleum Institute (the entire disclosure of which is hereby incorporated as if reproduced in its entirety).

**[0055]** Each batch was formed from a cement mix comprising a base blend comprising 100 weight percent Class A cement. Zeolite in the amount reported in Table 6, which is a percentage based on the weight of the base blend of the cement mix ("% bwob"), was mixed with the cement mix as an additive. The specific zeolite material used was chabazite, which was obtained from C2C Zeolite Corporation, Calgary, Canada. A dispersant was also mixed with the cement mix as an additive in the amount as reported in Table 6, which is reported as a percentage based on the weight of the base blend (% bwob). The specific dispersant used was a sulfonated ketone acyclic aldehyde condensate available from Halliburton Energy Services. The water amounts for each batch are reported as percentages based on the weight of the base blend.

**[0056]** Fluid loss was tested under standard conditions according to Section 10 of API Specification RP 10B, 22<sup>nd</sup> Edition, 1997, of the American Petroleum Institute (the entire disclosure of which is hereby incorporated as if reproduced in its entirety).

TABLE 6

Components	Batch 1	Batch 2	Batch 3	Batch 4	Batch 5	Batch 6	Batch 7	Batch 8	Batch 9
Cement %	100	100	100	100	100	100	100	100	100
Zeolite % bwob	0	5	10	0	5	10	0	5	10
Dispersant % bwob	0	0	0	1	1	1	1.5	1.5	1.5
Water % bwob	46.6	47.8	49	46.0	47.8	49	45.8	47.8	49
Density kg/m <sup>3</sup> (lb/gal)	1872 (15.6)								
Fluid loss at 80°F (cc/30min)	612	515	417	261	190	139	164	136	89
Fluid loss at 150°F (cc/30min)	590	482	417	328	110	91	287	120	69

[0057] TABLE 6 shows that cement compositions comprising zeolite (Batches 2, 3, 5, 6, 8, and 9) control fluid loss better than conventional cement compositions. Also, the fluid loss control improves with increasing concentration of the dispersant.

#### EXAMPLE 7

[0058] Components in the amounts listed in TABLE 7 were added to form seven batches of a lightweight pozzolanic cement composition. The initial density was conventionally measured, and reported in both metric units, kilogram per cubic meter ("kg/m<sup>3</sup>") and imperial, pounds per gallon ("lb/gal"). The batches were prepared according to API Specification RP 10B, 22<sup>nd</sup> Edition, 1997, of the American Petroleum Institute (the entire disclosure of which is hereby incorporated as if reproduced in its entirety).

[0059] Batches 1, 3, and 6 were formed from a cement mix that comprised a base blend comprising 56 weight percent Class C cement, 22 weight percent fly ash, and 22 weight percent fumed silica. The fly ash was Class F fly ash, commercially available from Halliburton Energy Services. Fumed silica was obtained from either Fritz Industries, Mesquite, Texas, USA, or Elkem Group, Oslo, Norway.

[0060] Batches 2, 4, and 7 were formed from a cement mix that comprised a base blend comprising 56 weight percent Class C cement, 22 weight percent fly ash, and 22 weight percent zeolite. The fly ash was Class F fly ash, commercially available from Halliburton Energy Services. The specific zeolite material used was chabazite, which was obtained from C2C Zeolite Corporation, Calgary, Canada.

[0061] Batch 5 was formed from a cement mix that comprised a base blend comprising 100 weight percent Class C cement.

[0062] Water was added to each cement mix to form a cement composition. The water amounts for each of the seven batches are reported in Table 7 as percentages based on the weight of the base blend ("% bwob") of each cement mix.

[0063] Under standard conditions set out in Section 15.6, Sedimentation Test, of API Specification RP 10B, 22<sup>nd</sup> Edition, 1997, of the American Petroleum Institute, the batches were placed in corresponding cylinders and allowed to set for 24 hours. Each cylinder was then divided into segments, and the density for each segment was determined by conventional means. It is understood that the absence of settling is indicated by minimal variation in density values among the sections of a given cylinder, as shown in Table 7.

**TABLE 7**

	<b>Batch 1</b>	<b>Batch 2</b>	<b>Batch 3</b>	<b>Batch 4</b>	<b>Batch 5</b>	<b>Batch 6</b>	<b>Batch 7</b>
<b>Components</b>							
Cement %	56	56	56	56	100	56	56
Fly ash %	22	22	22	22	0	22	22
Fumed silica %	22	0	22	0	0	22	0
Zeolite %	0	22	0	22	0	0	22
Water (% bwob)	110	110	110	110	110	110	110
Initial density kg/m <sup>3</sup> (lb/gal)	1440 (12.0)						
Temperature °C (°F)	27 (80)	27 (80)	82 (180)	82 (180)	93 (200)	93 (200)	93 (200)
<b>Settling Data</b>							
Top Segment MPa (lb/gal)	1392 (11.6)	1476 (12.3)	1404 (11.7)	1488 (12.4)	1524 (12.7)	1476 (12.3)	1548 (12.9)
2nd Segment MPa (lb/gal)	1440 (12.0)	1488 (12.4)	1404 (11.7)	1500 (12.5)	--	--	--
3rd Segment MPa (lb/gal)	1440 (12.0)	1488 (12.4)	1404 (11.7)	1488 (12.4)	1596 (13.3)	1476 (12.3)	1536 (12.8)
4th Segment MPa (lb/gal)	1428 (11.9)	1488 (12.4)	--	1476 (12.3)	--	--	--

	<b>Batch 1</b>	<b>Batch 2</b>	<b>Batch 3</b>	<b>Batch 4</b>	<b>Batch 5</b>	<b>Batch 6</b>	<b>Batch 7</b>
Bottom Segment MPa (lb/gal)	1428 (11.9)	1488 (12.4)	1416 (11.8)	1476 (12.3)	1572 (13.1)	1452 (12.1)	1548 (12.9)
Comments	settling	no settling	no settling	no settling	settling	no settling	no settling

[0064] TABLE 7 shows that batches with zeolite (Batches 2, 4, and 7) did not settle.

#### **EXAMPLE 8**

[0065] To illustrate the effectiveness of accelerating agents with cement compositions comprising zeolites, ten cement compositions, each having a density of about 1400 kg/m<sup>3</sup> (11.68 lb/gal), were prepared according to API Specification RP 10B, 22<sup>nd</sup> Edition, 1997, of the American Petroleum Institute (the entire disclosure of which is hereby incorporated as if reproduced in its entirety). Following said API specification, a cement mix comprised of a base blend comprising 60 weight percent Class C cement and 40 weight percent zeolite was formed by dry-mixing the cement and the zeolite by hand in a glass jar. Clinoptilolite, which is commercially available from C2C Zeolite Corporation of Calgary, Canada, was used as the zeolite for each base blend.

[0066] Sodium sulfate and sodium carbonate in the amounts listed in TABLE 8 were dry-mixed into the cement mix to act as accelerating additives. The sodium sulfate and sodium carbonate amounts are reported as percentages of the weight of the base blend (% bwob) of each cement mix.

[0067] The cement-zeolite base blend and the accelerating additives comprised the cement mix from which a cement composition was formed. The cement composition was formed by adding the cement mix to mixing fluid being maintained in a blender at 4000 RPM. All of the cement mix was added to the mixing fluid over a 15 second period. A cover was then placed on the blender, and mixing was continued at about 12,000 RPM for about 35 seconds. For each of

the ten cement compositions, the mixing fluid was water, in an amount of 135% bwob, which indicates a percentage based on total weight of the base blend of the cement mix. The cement mix temperature and mixing fluid temperature were both 24°C (75°F).

**TABLE 8**

Comp. No.	Na <sub>2</sub> SO <sub>4</sub> (% bwob)	Na <sub>2</sub> CO <sub>3</sub> (% bwob)	Compressive strength at 30°C (86°F)				
			Time (Hr:Min) to 0.35 MPa (50 psi)	Time (Hr:Min) to 3.5 MPa (500 psi)	MPa (psi) at 12 Hrs	MPa (psi) at 24 Hrs	MPa (psi) at 48 Hrs
1	6.00	0.0	6:12	46:11	1.09 (158)	2.37 (343)	3.73 (541)
2	7.00	0.0	7:17	39:04	0.88 (128)	2.19 (317)	4.14 (600)
3	6.95	0.05	6:49	42:41	1.01 (146)	2.32 (336)	4.29 (622)
4	6.90	0.10	7:13	36:18	0.88 (128)	2.28 (330)	4.44 (643)
5	6.75	0.25	2:45	31:31	1.03 (149)	2.41 (349)	4.55 (659)
6	6.50	0.50	7:20	34:03	1.01 (146)	2.48 (359)	4.49 (651)
7	6.00	1.00	6:27	32:42	1.22 (177)	2.60 (377)	4.62 (670)
8	6.00	*1.00	4:03	33:38	1.42 (206)	2.64 (383)	4.62 (670)
9	6.50	**0.5	--	29:53	1.65 (239)	2.94 (426)	4.76 (690)
10	6.00	**1.0	6:57	31:33	1.21 (175)	2.83 (410)	4.97 (720)

\*hand-ground in an agate mortar

\*\*laboratory grade from Baker chemicals

[0068] The time it takes for a cement composition to reach a designated MPa (psi) value is a measurement of the effectiveness of the accelerating additive. **Table 8** illustrates that sodium sulfate, sodium carbonate, and a combination of sodium sulfate and sodium carbonate are effective accelerators for cement compositions comprising zeolite.

[0069] The 0.35 MPa and 3.5MPa values were selected as general testing points. These general testing points are based on the fact that one of ordinary skill in the art would consider that at 0.35 MPa, a cement composition is beginning to set, while at 3.5MPa, the cement composition has enough strength to hold the casing pipe in place. With respect to measuring compressive strength at 12, 24, and 48 hours, these values were also selected as arbitrary standards within the industry as a means for providing comparable data points. It is understood that compressive strength could be measured at other values of MPa and at other elapsed times. It may be desirable to do so when industry standards require that a certain MPa value be achieved

in a certain amount of time. For example, EUB in Alberta Canada requires a compressive strength of 3.5 MPa in 48 hours.

[0070] Although the embodiment exemplified by Example 8 has been described with reference to sodium carbonate and sodium sulfate as accelerators, other accelerators, such as calcium sulfate and potassium sulfate, which are referred to herein as sulfate salts, and calcium carbonate and potassium carbonate, which are referred to herein as carbonate salts, would also achieve the illustrated effectiveness. Accordingly, when a combination of accelerators is used, it will be understood by those of ordinary skill in the art that a number of combinations comprising any of the sulfate salts with any of the carbonate salts can be used.

#### **EXAMPLE 9**

[0071] **Table 9A** illustrates fluid loss control additives that are effective in cement compositions containing zeolite. Twelve cement compositions, each having a density of about 1400 kg/m<sup>3</sup> (11.68 lb/gal), were prepared according to API Specification RP10B, 22<sup>nd</sup> edition, 1997, of the American Petroleum Institute, the entire disclosure of which is incorporated herein by reference. According to this API specification, a cement mix comprised of a base blend comprising 60 weight percent Class C cement and 40 weight percent zeolite was formed by dry-mixing the cement and the zeolite by hand in a glass jar. Clinoptilolite, which is commercially available from C2C Zeolite Corporation of Calgary, Canada, was used as the zeolite in each base blend.

[0072] Sodium sulfate in an amount of 7% bwob, which indicates a percentage by weight of the base blend, was dry-mixed into each cement mix as an accelerating additive. Fluid loss additives (FLAs) as listed in **Table 9A** were also dry-mixed into the cement mix in the amount as listed, which is also reported as a percentage by weight of the base blend.

[0073] The cement-zeolite base blend and the accelerating and fluid loss additives comprised the cement mix from which a cement composition was formed. The cement composition was formed by adding the cement mix to a mixing fluid being maintained in a blender at 4000 RPM. The cement mix was added to the mixing fluid over a 15 second period. When all of the cement

mix was added to the mixing fluid, a cover was placed on the blender and mixing was continued at about 12,000 RPM for about 35 seconds. For each cement composition, the mixing fluid was water. The amount of water required in the blender was 135% bwob, which indicates a percentage based on total weight of the base blend of the cement mix. The cement mix temperature and mixing fluid temperature were both 24°C (75°F).

**TABLE 9A**

Comp. No.	Fluid Loss Additive ("FLA")	FLA Charge Character	FLA Concentration (% bwob)	Other Additive and Concentration of Other Additive (% bwob)	API Fluid Loss (mL/30 min)
1	none	N/A	N/A	none	787
2	HEC (hydroxyethylcellulose)	non-ionic	1.0	none	54
3	hydrophobically modified HEC (Natrosol Plus 330™)	non-ionic	1.0	none	70
4	hydrophobically modified HEC (Natrosol Plus 330™)	non-ionic	0.75	none	140
5	hydrophobically modified HEC (Natrosol Plus 330™)	non-ionic	0.5	none	321
6	CMHEC (carboxymethyl hydroxyethylcellulose)	anionic	1.0	none	274
7	Guar	anionic	1.0	none	736
8	Modified Guar	anionic	1.0	none	660
9	LAP-1	non-ionic	1.0	Bentonite 1.0	372
10	Halad 344	anionic	1.0	none	248
11	Halad 413	anionic	1.0	none	150
12	Starch	non-ionic	1.0	none	431

[0074] HEC (Comp. No. 2) is commercially available from Dow/Union Carbide of Midland, Michigan. Hydrophobically modified HEC (Comp. Nos. 3 – 5) is commercially available as Natrosol Plus 330™ from the Aqualon Division (Kennedy, Texas) of Hercules Incorporated. CMHEC (Comp. No. 6) is commercially available from Drilling Specialties Company (Houston, Texas), a division of Chevron Philips Chemical. Guar (Comp. No. 7) and modified guar (Comp. No. 8) are commercially available from Rhone-Poulenc. LAP-1 and bentonite (Comp. No. 9) are a polyvinyl alcohol and a montmorillonite clay respectively, and are each commercially available from Halliburton Energy Services, Duncan, Oklahoma. Halad 344 (Comp. No. 10) are grafted

polymers prepared by the polymerization of monomers or salts of monomers of N,N-dimethylacrylamide, 2-acrylamido-2-methylpropanesulfonic acid and acrylonitrile having a lignin or lignite or other backbone, and are commercially available from Halliburton Energy Services, Duncan, Oklahoma. Halad 413 (Comp. No. 11) are copolymers or salts of copolymers of N,N-dimethylacrylamide (NNDMA) and 2-acrylamido, 2-methyl propane sulfonic acid (AMPS), and are commercially available from Halliburton Energy Services.

[0075] Fluid loss was tested by following procedures set forth in Section 10 of API Recommended Practice 10B, 22<sup>nd</sup> Edition, 1997, of the American Petroleum Institute (the entire disclosure of which is hereby incorporated as if reproduced in its entirety).

[0076] The procedures followed were those for testing at temperatures less than 194°F, with atmospheric pressure conditioning, and a static fluid loss cell. Generally, however, 475 cc of each composition was placed into the container of an atmospheric pressure consistometer commercially available from Howco. The composition was cooled to the test temperature of 20°C (68°F) over a 5 minute period, where the temperature of the atmospheric consistometer was controlled by the temperature of a bath. The test temperature of 20°C (68°F) was an arbitrarily chosen value based on typical values for bottom hole circulating temperature (BHCT) of a well. After 20 minutes, the composition was stirred, and then the fluid loss cell was filled.

[0077] A 5 inch standard fluid loss cell was prepared according to the aforementioned Section 10 of API Recommended Practice 10B. Generally, however, the test was started within 30 seconds of closing the cell by application of nitrogen applied through the top valve. Filtrate was collected and the volume and time were recorded if blow out occurred in less than 30 minutes or volume recorded at 30 minutes if no blow out occurred. Thus, to report fluid loss data indicated in Table 9A, values were calculated as twice the volume of filtrate multiplied by 5.477 and divided by the square root of time if blowout occurred, and as twice the volume of filtrate if blowout did not occur within 30 minutes.

[0078] Lower amounts (mL/30 Min) of fluid loss as compared to the fluid loss amount of Comp. No. 1 illustrate the effectiveness of the FLAs in those cement compositions. Thus, fluid

loss control additives that are effective on cement compositions comprising zeolite are illustrated. Of the twelve cement compositions tested, the non-ionic hydroxyethyl cellulose (HEC) (Comp. No. 2), and hydrophobically modified HEC (Comp. Nos. 3 - 5) provided the best fluid loss control. The anionic CMHEC (Comp. No. 6), Halad 413 (Comp. No. 11), Halad 344 (Comp. No. 10), non-ionic starch (Comp. No. 12), and LAP-1/Bentonite mix (Comp No. 9) provided fluid loss control to a lesser degree. Guar, (Comp No. 7) and modified guar (Comp No. 8) provided only a small degree of fluid loss control.

[0079] Additional fluid loss control testing was conducted on cement compositions comprising non-ionic hydrophobically modified HEC (Natrosol Plus 330<sup>TM</sup>). API fluid testing was conducted on the cement compositions listed in **Table 9B** at the indicated temperatures. The cement compositions listed in **Table 9B** were prepared in the same manner as described above for the compositions listed in **Table 9A**. As described above, base blends comprising 60 weight percent Class C cement and 40 weight percent zeolite were dry-mixed by hand in a glass jar. Clinoptilolite, which is commercially available from C2C Zeolite Corporation of Calgary, Canada, was used as the zeolite in each base blend.

[0080] Sodium sulfate in an amount of 7% bwob (where "% bwob" indicates a percentage by weight of the base blend) was dry-mixed with each base blend as an accelerating additive. The non-ionic hydrophobically modified HEC (Natrosol Plus 330<sup>TM</sup>) FLA was also dry-mixed into each base blend in the % bwob as listed in **Table 9B**.

[0081] The cement-zeolite base blend and the accelerating and fluid loss additives comprised the cement mix from which a cement composition was formed. The cement composition was formed by adding the cement mix to a mixing fluid being maintained in a blender at 4000 RPM. All of the cement mix was added to the mixing fluid over a 15 second period. A cover was then placed on the blender and mixing was continued at about 12,000 RPM for about 35 seconds. For each cement composition, the mixing fluid was water, which was present in an amount of about 135% bwob, which is a percentage based on weight of the base blend. The density of each cement composition was about 1400 kg/m<sup>3</sup> (11.68 lb/gal).

[0082] Fluid loss testing according to API procedure Section 10 of API Recommended Practice 10B as described above was conducted at the test temperatures indicated in Table 9B. The measured fluid loss values (mL of fluid lost/30 min) illustrate that non-ionic hydrophobically modified HEC is an effective fluid loss control agent for use with cement compositions containing zeolite at temperatures at least up to 80°C (176°F).

**TABLE 9B**

Comp. No.	Fluid Loss Additive ("FLA")	FLA Charge Character	FLA Concentration (% bwob)	API Fluid Loss Test Temperature °C (°F)	API Fluid Loss (mL/30 min)
1	hydrophobically modified HEC (Natrosol Plus 330™)	non-ionic	0.75	30 (86)	183
2	hydrophobically modified HEC (Natrosol Plus 330™)	non-ionic	0.75	40 (104)	399
3	hydrophobically modified HEC (Natrosol Plus 330™)	non-ionic	1.0	40 (104)	75
4	hydrophobically modified HEC (Natrosol Plus 330™)	non-ionic	0.75	50 (122)	427
5	hydrophobically modified HEC (Natrosol Plus 330™)	non-ionic	1.0	50 (122)	272
6	hydrophobically modified HEC (Natrosol Plus 330™)	non-ionic	0.75	80 (176)	804

#### **EXAMPLE 10**

[0083] Table 10 illustrates that zeolite is an effective flow enhancing agent. Flow enhancing agents relate to the flow properties of a dry cement mix. Thus, eight cement mixes comprising eight base blends were prepared by dry-mixing Class C cement and zeolite in the amounts as listed in Table 10 by hand in a glass jar. Chabazite, which is commercially available from C2C Zeolite Corporation of Calgary, Canada, was used as the zeolite for each base blend.

[0084] The base blend for cement mix nos. 7 and 8 comprised zeolite (chabazite) with acetic acid, a conventional flow enhancing agent, adsorbed thereon in the amount as indicated, where "% bwoZ" is a percentage based on the weight of the zeolite. To absorb the acetic acid on the zeolite, 10 g of zeolite was weighed into a beaker. The required percentage by weight of acetic

acid was added by dropper. The zeolite and acetic acid were then mixed with a spatula to give a homogenous powder with adsorbed acetic acid.

[0085] A pack set test method was used to obtain an indication of the flow properties of the eight dry cement mixes. The pack set test is empirical, as there is no direct correlation with the flow properties of the powder. However, it is understood by one of ordinary skill in the art that dry-mixes with a pack set index of about 10 or less will typically flow efficiently in field applications.

[0086] The pack set test was conducted as follows for each cement mix. First, at least 400 grams of the base blend of each cement mix was isolated by placing it into a glass jar with a lid. An amount of each base blend was weighed into a 250 mL Erlenmeyer flask to obtain approximately 100 cc volume in the flask. The flask was then stoppered with a rubber stopper, and placed on a vibrating table. Using a variable transformer, the flask was vibrated at a dial reading of 48 for a time period of 24 seconds. The flask was then placed between the four rubber projections of a Roto-Tester, which is a device commercially available from W.R. Grace. The counter of the Roto-Tester was set to zero and then the Roto-Tester was turned on. The number on the counter was recorded when the material in the flask first began to unpack, which is indicated below in Table 10 as the initial slough-off. The number on the counter was again recorded when all of the material in the flask had unpacked, which is indicated in Table 10 as the complete slough-off.

TABLE 10

Mix No.	Weight Percent API Class C Portland Cement.	Weight Percent Zeolite (chabazite)	Number of Revolutions– Initial Slough-Off	Number of Revolutions – Complete Slough-Off
1	100	0	12.7	14.7
2	99	1	11.5	13.0
3	95	5	7.3	8.3
4	90	10	8.4	9.4

Mix No.	Weight Percent API Class C Portland Cement.	Weight Percent Zeolite (chabazite)	Number of Revolutions—Initial Slough-Off	Number of Revolutions – Complete Slough-Off
5	85	15	4.7	5.7
6	65	35	4.0	5.0
7	99.5	0.5 with 25% bwoZ acetic acid	3.4	4.6
8	99	1 with 15% bwoZ acetic acid	4.0	5.2

[0087] The slough-off values in Table 10 indicate that cement compositions formed from cement mixes comprising base blends comprising zeolite will flow efficiently when used in field applications. In addition, these values indicate that the zeolite also behaves as friction reducer. Friction reduction and flow enhancement are considered to be similar properties.

#### **Example 11**

[0088] **Tables 11A and 11B** illustrate that cement mixes comprising zeolite as a part of the base blend are useful in forming cement compositions having good compressive strength, which may also be considered “lightweight” cements, as densities equal to or less than about 13.5 lb/gal can be achieved.

[0089] Six cement compositions, each having a density as indicated in **Table 11A** were prepared according to API Specification RP 10B, 22<sup>nd</sup> Edition, 1997, of the American Petroleum Institute (the entire disclosure of which is hereby incorporated as if reproduced in its entirety). The density was conventionally measured, and reported in both metric units, kilogram per cubic meter (“kg/m<sup>3</sup>”) and imperial, pounds per gallon (“lb/gal”).

[0090] Composition Nos. 1 and 4 were formed from a cement mix comprising a base blend comprising 100 weight percent Class G cement. The cement mix was mixed with a mixing fluid comprising water and prehydrated bentonite in the amounts reported in Table 11A, where the water amount is reported as a percentage by weight of the base blend of the cement mix, and the prehydrated bentonite is reported as a percentage by weight of the amount of mixing fluid

(water). Prehydrated bentonite is bentonite that is mixed in water and added to the mixing fluid as a liquid, where 1% of prehydrated bentonite is equivalent to 4 – 5% dry blended bentonite. Bentonite is a montmorillonite clay commercially available from Halliburton Energy Services, Duncan, Oklahoma.

[0091] Composition Nos. 2, 3, 5 and 6 were each formed from a cement mix comprising a base blend comprised of Class G cement and zeolite in the amounts (weight percents) reported in Table 11A. The cement and the zeolite were dry-mixed by hand in a glass jar. Chabazite, which is commercially available from C2C Zeolite Corporation of Calgary, Canada, was used as the zeolite for each cement composition. CFR-3 was also dry-mixed by hand in the glass jar with the base blend in the amount as listed in Table 11A, where % bwob indicates a percentage by weight of the base blend. CFR-3 is the tradename for the condensation product of formaldehyde, acetone and a sulfite, which is commercially available from Halliburton Energy Services.

[0092] The cement-zeolite base blend and the CFR-3 dispersant comprised the cement mix from which a cement composition was formed. The cement composition was formed by adding the cement mix to mixing fluid being maintained in a blender at 4000 RPM. The cement mix was added to a mixing fluid over a 15 second period. When all of the cement mix was added to the mixing fluid, a cover was placed on the blender and mixing was continued at about 12,000 RPM for about 35 seconds. For cement composition Nos. 2, 3, 5 and 6, the mixing fluid comprised water in the amount as listed in Table 11A where % bwob indicates a percent by weight of the base blend. The temperatures of the cement mix and the mixing fluid were each 24 °C (75°F).

TABLE 11A

Components	No. 1	No. 2	No. 3	No. 4	No. 5	No. 6
Class G Cement (wt. %)	100.00	65.00	50.00	100.00	60.00	50.00
Zeolite (wt. %)	0	35.00	50.00	0	40.00	50.00
CFR-3 (% bwob)	0	0	1.00	0	0	0
Water (% bwob)	80.13	69.49	65.36	108.50	93.00	89.81
Prehydrated Bentonite (% ww)	2.00	0	0	3.00	0	0

Components	No. 1	No. 2	No. 3	No. 4	No. 5	No. 6
Density kg /m <sup>3</sup> (lb/gal)	1620 (13.5)	1620 (13.5)	1620 (13.5)	1500 (12.5)	1500 (12.5)	1500 (12.5)

[0093] The six cement compositions were then tested, which yielded the rheology, compressive strength, free water, and settling data as indicated in **Table 11B**.

[0094] The viscosity (dial reading) of the cement compositions was measured using a Fann Model 35 viscometer, and reported in the Rheology Results in **Table 11B**. The viscosity was taken as the measurement of the dial reading on the Fann Model 35 at the different rotational speeds as indicated in 600 to 3 RPM, and at the temperature as indicated in **Table 11B**. For example, the Fann Viscometer is rotated at 300 RPM (revolutions per minute) for 60 seconds and a value on the dial is read, the speed is then changed to 200 RPM and the new value on the dial reading taken. There are a number of theoretical models known to those of ordinary skill in the art that can be used to convert the values from the dial readings at the different RPM's into viscosity (centipoises). In addition, different viscometer models use different RPM values, thus, in some instances, a measurement is not available at a particular RPM value.

[0095] The Rheology Results were obtained generally according to the procedures set forth in Section 12 of the API Specification RP 10B, 22<sup>nd</sup> Edition, 1997, of the American Petroleum Institute (the entire disclosure of which is hereby incorporated as if reproduced in its entirety). The aforementioned API procedures were modified in that the initial reading at 300 RPM was taken after 60 seconds of continuous rotation at that speed. Dial readings at 200, 100, 60, 30, 6 and 3 were then recorded in descending order at 20-second intervals. The final reading at 600 RPM was taken after 60 seconds of continuous rotation at that speed.

[0096] Free water data was gathered according to Section 15.5 of Addendum 2 of the API Specification 10B 22<sup>nd</sup> Edition, 1997, of the American Petroleum Institute, the entire disclosure of which is hereby incorporated herein by reference. Generally according to said API Specification, 250 ml of each cement composition was poured into its own 250 ml graduated glass cylinder and then sealed with a plastic film wrap to prevent evaporation. A two hour test

period was then initiated, in which the graduated cylinders were left standing. After two hours, the free fluid that had gathered on top of each cement composition inside the cylinder was measured. The percent of free fluid was calculated as the measured milliliters of free fluid multiplied by 100 and then divided by the initial 250 milliliters of the cement composition.

[0097] Settling data is based on observation of the degree of sample settling in the free water tests.

**Table 11B**

Comp. No.	Rheology Results Dial Reading at 49°C (120°F)								Compress. Strength Results Test Temp. at 66°C (150°F)			Free Water at 49°C (120°F) (mL/ 250mL)	Settling
	600 RPM	300 RPM	200 RPM	100 RPM	60 RPM	30 RPM	6 RPM	3 RPM	Time to 3.5 MPa (500 psi) Hr: Min	MPa (psi) at 12 Hrs	MPa (psi) at 24 Hrs		
1	125	100	96	93	90	86	30	18	10:19	4.01 (581)	5.74 (832)	6	None
2	128	106	97	85	79	71	34	27	6:04	12.5 (1815)	14.30 (2072)	0	None
3	245	190	164	135	119	101	48	38	4:16	13.92 (2017)	14.48 (2098)	0	None
4	98	82	78	73	70	68	38	27	>24	1.70 (246)	2.70 (391)	3	None
5	55	52	46	34	31	28	20	13	7:17	7.86 (1139)	9.00 (1304)	3	None
6	75	63	57	50	46	43	26	18	5:20	8.32 (1206)	9.06 (1314)	1	None

[0098] The data in Table 11B illustrates that lightweight cement compositions formed from cement mixes that comprised a base blend comprising zeolite (Nos. 2, 3, 5 and 6) possess properties comparable to lightweight cement compositions formed from conventional cement mixes (Nos. 1 and 4). In particular, cement composition Nos. 2, 3, 5 and 6 achieved greater compressive strengths than cement compositions Nos. 1 and 4, and in less time. For example, cement composition No. 4 only reached 2.7 MPa in 24 hours, while cement composition Nos. 2, 3, 5 and 6 achieved far greater compressive strengths in the same time period. In addition, in cement composition Nos. 2, 3, 5 and 6, the lack of settling indicates that there is no segregation of the lower density material, and the free water data indicates that the amount of supernatant

water that separated from the composition after standing for the test period was less than 3.5 mL per 250mL.

#### **EXAMPLE 12**

**[0099]** Tables 12A and 12B illustrate the effectiveness of microfine zeolites (zeolites with a mean particle size of about 3 to about 15 micrometers) for forming lightweight cement compositions having good compressive strength.

**[0100]** Seven cement compositions, each having the density as indicated in Table 12A were prepared according to API Specification RP 10B, 22<sup>nd</sup> Edition, 1997, of the American Petroleum Institute (the entire disclosure of which is hereby incorporated as if reproduced in its entirety).

**[0101]** Cement composition Nos. 1 and 2 were prepared from a cement mix comprising a base blend comprised of Class C cement and zeolite in the amounts (as weight percents) reported in Table 12A. The cement and zeolite were dry-mixed by hand in a glass jar, and then sodium sulfate and sodium carbonate were dry-mixed into the base blend as additives in the amounts as listed in Table 12A, where % bwob indicates a percentage by weight of the base blend. Clinoptilolite, which is commercially available from C2C Zeolite Corporation of Calgary, Canada, was used as the zeolite in the base blend of the cement mix for each of cement composition Nos. 1 and 2. The zeolite used to form the base blend of the cement mix for composition no. 1 had a particle size of about 13.12 micrometers, while the zeolite used to form the base blend of the cement mix for composition no. 2 had a particle size of about 182.86 micrometers.

**[0102]** Cement composition Nos. 3 – 7 were each formed from a cement mix comprising a base blend comprising 100 weight percent Class G cement. Zeolite in the amount listed in Table 12A was dry-mixed by hand in a glass jar with each cement mix as an additive, where “% bwob” indicates a percentage by weight of the base blend. Chabazite, which is commercially available from C2C Zeolite Corporation of Calgary, Canada, was used as the zeolite in the cement mixes for cement compositions nos. 3 – 7.

**[0103]** The cement mix for each of composition Nos. 1 – 7 comprised the base blend for each composition, plus the additives as listed in Table 12A. The cement compositions were prepared by

addition of the cement mix over a 15 second period to a mixing fluid being held in a blender at 4000 RPM. When all of the cement mix was added to the mixing fluid, a cover was placed on the blender and mixing was continued at about 12,000 RPM for about 35 seconds. The temperature of each mix and mixing fluid was (24°C)75°F.

[0104] For cement composition nos. 1 and 2, the mixing fluid comprised water and a defoaming agent comprising polypropylene glycol, particulate hydrophobic silica and a liquid diluent, which is commercially available from Halliburton Energy Services, Duncan, Oklahoma under the tradename D-air 3000L. The water used to form cement composition nos. 1 and 2 is reported in Table 12A as a percent by weight of the base blend (% bwob) of each cement mix, and the amount of D-air 3000L is reported as L/sk (gal/sk), which indicates liters (or gallons) per sack of cement composition.

[0105] For cement composition nos. 3 - 7, the mixing fluid comprised water in the % bwob as listed in Table 12A.

TABLE 12A

Base Blend of Cement Mix	No. 1	No. 2	No. 3	No. 4	No. 5	No. 6	No. 7
Class C cement (wt. %)	60.0	60.0	0	0	0	0	0
Class G cement (wt. %)	0	0	100	100	100	100	100
Clinoptilolite (Zeolite) (wt. %)	40.0 13.12 µm particle size	40.0 182.86 µm particle size	0	0	0	0	0
Cement Mix Additives							
Chabazite (Zeolite) % bwob	0	0	10 3.75 µm particle size	10 5.17 µm particle size	10 12.62 µm particle size	10 126.30 µm particle size	10 2675.0 µm particle size
Sodium sulfate % bwob	6.9	6.9	0	0	0	0	0
Sodium carbonate % bwob	0.1	0.1	0	0	0	0	0

Mixing Fluid							
D-air 3000L	0.329 L/sk 0.037 gal/sk	0.329 L/sk 0.037 gal/sk	0	0	0	0	0
Water % bwob	134.99	134.99	113.02	113.02	113.02	113.02	113.02
Properties	No. 1	No. 2	No. 3	No. 4	No. 5	No. 6	No. 7
Density	1400 kg/m <sup>3</sup> (11.68 lb/gal)	1400 kg/m <sup>3</sup> (11.68 lb/gal)	1500 kg/m <sup>3</sup> (12.5 lb/gal)	1500 kg/m <sup>3</sup> (12.5 lb/gal)	1500 kg/m <sup>3</sup> (12.5 lb/gal)	1500 kg/m <sup>3</sup> (12.5 lb/gal)	1500 kg/m <sup>3</sup> (12.5 lb/gal)
Yield	1.73 m <sup>3</sup> /t (2.61 ft <sup>3</sup> /sk)	1.73 m <sup>3</sup> /t (2.61 ft <sup>3</sup> /sk)	1.48 m <sup>3</sup> /t (2.24 ft <sup>3</sup> /sk)				

[0106] Compressive strength data for each cement composition and free fluid data of a suspension of the particular zeolite used in each cement composition tested are indicated in **Table 12B**. The compressive strength data was determined by Non-Destructive Sonic Testing as set forth in API Specification 10B 22<sup>nd</sup> Edition, 1997, of the American Petroleum Institute, the entire disclosure of which is hereby incorporated herein by reference. The free fluid data was gathered to show the effect of fineness of the zeolite on antisettling. A 48% suspension of the particular zeolite used for each of cement composition nos. 1- 7 was prepared by mixing 288g of the particular zeolite with 312g of water in a blender at 2000 rpm for 1 minute. 250 mL of each zeolite suspension was poured into its own 250 ml graduated glass cylinder and then sealed with a plastic film wrap to prevent evaporation. A ninety-six hour test period was then initiated, during which the graduated cylinders were left standing. The free fluid that had gathered on top of each zeolite suspension inside the cylinder was measured. The percent of free fluid was calculated by multiplying the mL of free fluid gathered by 100, and then dividing the product by 250mL. The amount of free fluid formed provides an indication of settling, where a zero percent value indicates no settling.

**TABLE 12B**

Cement Comp. No.	Comp. Strength Test	Compressive Strength MPa (psi)				Free fluid development (% of free fluid formed on an aqueous suspension of the particular zeolite used in each of Cement Comp. Nos. 1 - 7)							
		Temp. °C (°F)	12 hr	24 hr	48 hr	96 hr	10 min	30 min	1 Hr	2 Hr	18 Hr	24 Hr	48 Hr
1	30 (86)	1.52 (220)	2.91 (422)	4.69 (680)	--	0	0	2	2	15	16	23	30
2	30 (86)	1.36 (197)	2.46 (357)	3.17 (460)	--	14	45	70	80	86	86	86	86
3	66 (150)	no data	no data	no data	no data	0	0	0	0	0	0	0	0
4	66(150)	2.82 (409)	4.24 (615)	5.24 (760)	5.52 (800)	0.0	0.0	0.4	0.4	2.0	2.4	4.0	4.8
5	66 (150)	3.17 (460)	4.62 (669)	6.00 (870)	6.90 (1000)	0.0	0.0	0.4	0.4	2.4	3.2	4.8	5.6
6	66 (150)	2.37 (344)	3.71 (538)	4.83 (700)	5.52 (800)	0.8	14.4	17.6	18.4	18.4	18.4	18.4	19.2
7	66 (150)	0 (0)	0 (0)	0 (0)	not set	11.1	11.1	11.1	11.1	12.2	18.8	18.8	20.0

[0107] The data in Table 12B illustrates that cement compositions comprising zeolites having a mean particle size of equal to or less than about 15 micrometers show an improved rate of early compressive strength development over cement compositions comprising zeolites having a mean particle size of equal to or greater than about 100 micrometers. In addition, Table 12B illustrates that the improved rate of early compressive strength exhibited by the cement compositions with the finer particle size zeolite is achievable at a broad range of temperatures. The free fluid data illustrates that zeolite suspensions comprising zeolites having a mean particle size of equal to or less than about 15 micrometers show less free fluid development over time than zeolite suspensions comprising zeolites having a mean particle size of equal to or greater than about 100 micrometers. Zeolite suspensions comprising zeolites having a mean particle size less than about 5 micrometers have no free fluid development, indicating excellent antisettling properties.

### **EXAMPLE 13**

[0108] Example 13 illustrates that zeolites can be used as dispersants to reduce the apparent viscosity of cement compositions.

[0109] Twelve cement compositions were prepared according to API Specification RP 10B, 22<sup>nd</sup> Edition, 1997, of the American Petroleum Institute (the entire disclosure of which is hereby incorporated as if reproduced in its entirety).

[0110] Composition Nos. 1 - 9 were each formed from a cement mix comprising a base blend comprised of the components in the amounts (as weight percents) listed in Table 13A. Each base blend was prepared by dry-mixing by hand in a glass jar the amounts of the components as listed in Table 13A. As shown in Table 13A, the components selected for each base blend varied, (e.g., cements of Classes A, C, H, and G, fly ashes of Class F and G, silicalite, hydrated lime, and zeolite), and the amount of each components' contribution to the 100 weight percent of the base blend also varied.

[0111] Additives of the types and amounts (reported as a percentage by weight of the base blend (% bwob)) as listed in Table 13A were also dry-mixed in the glass jar with the base blend. The first exception to the foregoing is the NaCl, which although dry-mixed with the base blend, is reported as percentage by weight of water because it is known to affect density calculations of the cement composition when it is dissolved in water. The second exception to the foregoing is the prehydrated bentonite, which is reported as a percentage by weight of water because it was added to the mixing fluid for the particular base blend.

[0112] The base blend and the additives comprised the cement mix from which a cement composition was prepared. The cement composition was prepared by adding the cement mix to mixing fluid being maintained in a blender at 4000 RPM. All of the cement mix was added to the mixing fluid over a 15 second period. A cover was then placed on the blender and mixing was continued at about 12,000 RPM for about 35 seconds. The mixing fluid comprised water in the amount as listed in Table 13A, where % bwob indicates a percent by weight of the base blend comprising the cement mix.

[0113] Composition Nos. 10 - 12 were formed from a cement mix comprising a base blend comprising 100 weight percent of the cementitious material listed in Table 13A. Additives in the amounts listed in Table 13A, which are reported as a percentage by weight of the base blend, were dry-mixed by hand in the glass jar with the base blend. The exception to the foregoing was the prehydrated bentonite, which is reported as a percentage by weight of water because it was added to the mixing fluid for the particular cement mix.

[0114] The base blend and the additives comprised the cement mix from which a cement composition was prepared. The cement composition was prepared by adding the cement mix to mixing fluid in the manner described above with respect to cement composition Nos. 1 - 9. The cement mix for each of cement composition Nos. 10 and 11 was mixed with a mixing fluid comprising water in the amounts reported in Table 13A, which are reported as a percentage by weight of the base blend of the cement mix. The cement mix for cement composition No. 12 was mixed with a mixing fluid comprising water and prehydrated bentonite in the amounts reported in Table 13A, where the water amount is reported as a percentage by weight of the base blend, and the prehydrated bentonite is reported as a percentage by weight of the amount of water. Prehydrated bentonite is bentonite that is mixed in water and added to the mixing fluid as a liquid, where 1% of prehydrated bentonite is equivalent to 4 – 5% dry blended bentonite. Bentonite is a montmorillonite clay commercially available from Halliburton Energy Services, Duncan, Oklahoma.

[0115] The temperatures of the cement mix and the mixing fluid for all of the compositions listed in Table 13A were 24 °C (75°F).

TABLE 13A

	No. 1	No. 2	No. 3	No. 4	No. 5	No. 6	No. 7	No. 8	No. 9	No. 10	No. 11	No. 12
<b>Base Blend</b>												
Class A Cement (wt. %)	56	56	0	0	0	0	0	0	0	0	0	0
Class C cement (wt. %)	0	0	0	0	0	0	0	0	0	100	100	0

	No. 1	No. 2	No. 3	No. 4	No. 5	No. 6	No. 7	No. 8	No. 9	No. 10	No. 11	No. 12
Class H cement ( wt. %)	0	0	70	70	0	0	0	0	0	0	0	0
Class G cement ( wt. %)	0	0	0	0	67	56	70	26	88	0	0	100
Class F Fly Ash ( wt. %)	22	22	12.7	12.7	0	22	30	61	12	0	0	0
Class C Fly Ash ( wt. %)	0	0	4.6	4.6	0	0	0	0	0	0	0	0
Silicalite ( wt. %)	22	0	12.7	0	0	22	0	0	0	0	0	0
Zeolite ( wt. %)	0	22	0	12.7	33	0	0	0	0	0	0	0
Hydrated Lime ( wt. %)	0	0	0	0	0	0	0	13	0	0	0	0
	100	100	100	100	100	100	100	100	100	100	100	100
<b>Additives</b>												
Silicalite % bwob	0	0	0	0	0	0	0	0	0	6	0	0
Zeolite % bwob	0	0	0	0	0	0	0	0	0	0	6	0
Microsand % bwob	18	18	0	0	0	0	0	0	0	0	0	0
HR-12 % bwob	0.9	0.9	0	0	0	0	0	0	0	0	0	0
Bentonite % bwob	10	10	0	0	0	0	6	4	8	6	6	0
Halad-344 % bwob	0	0	0	0	0	0	0	0	0	0.3	0.3	0
FWCA % bwob	0	0	0	0	0	0	0	0	0	0.4	0.4	0
LAP-1 % bwob	0	0	0.5	0.5	0	0	0	0	0	0	0	0
HR-7% bwob	0	0	0.3	0.3	0	0	0	0	0	0	0	0

	No. 1	No. 2	No. 3	No. 4	No. 5	No. 6	No. 7	No. 8	No. 9	No. 10	No. 11	No. 12
NaCl (% ww)	0	0	3.67	3.67	0	0	0	0	0	0	0	0
Gilsonite % bwob	0	0	5.75	5.75	0	0	0	0	0	0	0	0
Flocele % bwob	0	0	0.29	0.29	0	0	0	0	0	0	0	0
CFR-3 % bwob	0	0	0.3	0	0	0	0	0	0	0	0	0
Prehydrated Bentonite (% ww)	0	0	0	0	0	0	0	0	0	0	0	3
Water (% bwob)	139.7	138.1	75.1	75.1	95.2	94.1	102.6	87.9	109.2	115.4	175.1	108.5

[0116] The zeolite used as either a component of the base blend of a cement mix, or as an additive to a cement mix was chabazite, which is commercially available from C2C Zeolite Corporation of Calgary, Canada.

[0117] Class F fly ash is a lightweight additive that is commercially available from Halliburton Energy Services as Pozmix A. Silicalite is a lightweight additive comprising fumed silica, and is commercially available from Halliburton Energy Services. Microsand is the brand name for a fine particle size high-purity crystalline silica commercially available from Halliburton Energy Services. HR-12 is a retarder comprising a lignosulfonate/organic acid blend, and is commercially available from Halliburton Energy Services. FWCA is a free water control additive comprising cellulose, and is commercially available from Halliburton Energy Services. HR-7 is a retarder comprising a lignosulfonate, and is commercially available from Halliburton Energy Services. Gilsonite is a loss circulation agent comprising a naturally occurring bitumen and is commercially available from Halliburton Energy Services. Flocele is a loss circulation agent comprising cellophane, and is commercially available from Halliburton Energy Services. CFR-3 is the tradename for a condensation product of formaldehyde, acetone and a sulfite, which is commercially available as a dispersant from Halliburton Energy Services.

[0118] Compressive strength and rheology data were determined for each composition. Compressive strength was tested according to Non-Destructive Sonic Testing as set forth in API Specification 10B 22<sup>nd</sup> Edition, 1997, of the American Petroleum Institute, the entire disclosure of which is incorporated herein by reference.

[0119] The viscosity (dial reading) of the cement compositions was measured using a Fann Model 35 viscometer, and reported in the Rheology Results in **Table 13B**. The viscosity was taken as the measurement of the dial reading on the Fann Model 35 at the different rotational speeds as indicated in 600 to 3 RPM, and at the temperature as indicated in **Table 13B**. For example, the Fann Viscometer is rotated at 300 RPM (revolutions per minute) for 60 seconds and a value on the dial is read, the speed is then changed to 200 RPM and the new value on the dial reading taken. There are a number of theoretical models known to those of ordinary skill in the art that can be used to convert the values from the dial readings at the different RPM's into viscosity (centipoises). In addition, different viscometer models use different RPM values, thus, in some instances, a measurement is not available at a particular RPM value.

[0120] The rheology data was obtained generally according to the procedures set forth in Section 12 of the API Specification RP 10B, 22<sup>nd</sup> Edition, 1997, of the American Petroleum Institute (the entire disclosure of which is hereby incorporated as if reproduced in its entirety). The aforementioned API procedures were modified in that the initial reading at 300 RPM was taken after 60 seconds of continuous rotation at that speed. Dial readings at 200, 100, 60, 30, 30 and 3 were then recorded in descending order at 20-second intervals. The final reading at 600 RPM was taken after 60 seconds of continuous rotation at that speed.

[0121] The results of the compressive strength (Compress. Strength) and rheology testing are reported below in Table 13B.

TABLE 13B

No.	Density kg/m <sup>3</sup> (lb/gal)	Dial readings Test Temp °C (°F)	Dial Readings									Compress. Strength Test Temp °C (°F)	Compress. Strength Measurement MPa (psi)
			600 RPM	300 RPM	200 RPM	100 RPM	60 RPM	30 RPM	6 RPM	3 RPM	12 Hr		
1	1440 (12.0)	82 (180)	--	30	26	22	21	20	19	18	121 (250)	3.08 (446)	3.30 (479)
2	1440 (12.0)	82 (180)	20	15	14	12	11	10	9	9	121 (250)	2.82 (408)	2.98 (432)
3	1584 (13.2)	60 (140)	--	39	33	27	24	21	19	18	82 (180)	0.08 (12)	0.11 (17)
4	1584 (13.2)	60 (140)	--	36	30	26	23	20	16	15	82 (180)	0.15 (21)	0.19 (27)
5	1500 (12.5)	49 (120)	40	30	27	25	23	20	19	18	66 (150)	7.16 (1037)	9.11 (1320)
6	1500 (12.5)	49 (120)	60	50	44	40	37	33	29	22	66 (150)	9.27 (1344)	10.76 (1559)
7	1500 (12.5)	49 (120)	59	50	48	47	46	45	35	22	66 (150)	1.725 (250)	4.42 (640)
8	1500 (12.5)	49 (120)	102	94	90	84	80	70	33	23	66 (150)	1.27 (184)	4.80 (695)
9	1500 (12.5)	49 (120)	89	77	75	71	70	69	34	26	66 (150)	2.17 (315)	3.14 (455)
10	1500 (12.5)	88 (190)	--	50	34	20	15	11	8	6	77 (170)	0.97 (140)	1.35 (195)
11	1500 (12.5)	88 (190)	--	42	28	18	13	9	6	5	77 (170)	0.72 (105)	1.15 (167)
12	1500 (12.5)	49 (120)	98	82	78	73	70	68	38	27	66 (150)	1.70 (246)	2.70 (391)

**[0122]** The rheology data in Table 13B illustrates that zeolites can be used as dispersants to reduce the apparent viscosity of cement compositions. Those compositions comprising zeolite have lower apparent viscosity values and retain good compressive strength.

#### Example 14

**[0123]** Table 14 illustrates another embodiment for the use of zeolite to prepare cement compositions. According to this embodiment, zeolite in an aqueous form is used to make cement compositions, where the aqueous zeolite imparts benefits to the cement compositions similar to those imparted by dry-mixed zeolites.

[0124] First, a base aqueous zeolite suspension comprising 48 weight percent zeolite was prepared by adding 7.2 kg of zeolite to 7.8 kg of water in a 5 gallon bucket, and stirring with a variable speed Premier Mill Corp. laboratory dispersator mixer at low speed until a homogenous suspension was obtained. This homogenous suspension served as a bulk sample, and was subsequently used to prepare the cement compositions listed in Tables 14A and 14D. To preserve the bulk sample, the bucket was sealed and then prior to use, was hand shaken to make sure the suspension was homogenous. The zeolite used to form the bulk sample was BZM ZeoFume, which is a micronized natural zeolite mineral comprised primarily of chabazite, is mined at the Bowie deposit in Arizona, and is commercially available from C2C Corporation.

[0125] Each cement composition was prepared according to the procedures set forth in API Specification RP10B, 22nd edition, 1997, of the American Petroleum Institute, the entire disclosure of which is incorporated herein by reference. Generally however, each cement composition was formed from a cement mix comprising a base blend comprising 100 weight percent Class G cement. The cement mixes for compositions 3, 5 and 7 further comprised zeolite as an additive, which was dry-mixed by hand with the Class G cement in the amount reported in Table 14A. The amount of zeolite as an additive is reported in % bwob, which indicates a percentage by weight of the base blend, namely the 100% of Class G cement. The zeolite dry-mixed into the cement mixes for compositions 3, 5 and 7 was the BZM ZeoFume described above.

[0126] The cement mixes for each of composition nos. 10 and 11 further comprised hydrated lime, which was dry-mixed with the base blend in an amount of 5% by weight of the base blend. The Class G cement, and the zeolite or hydrated lime comprised the cement mix from which each cement composition was prepared. The cement compositions were prepared by mixing each cement mix with a mixing fluid comprising water in the amount listed in Table 14A, which is reported as a percentage by weight of the base blend (% bwob) of each cement mix. For composition no. 8, the mixing fluid further comprised HR-6L in an amount of 0.07 gal/sk. HR-

6L is an aqueous solution of lignosulfonate, which is commercially available as a retarder from Halliburton Energy Services.

[0127] Prior to mixing of the cement mix with the mixing fluid, the mixing fluid was held in a blender set to operate at 4000 RPM, and the amount of the 48% aqueous zeolite suspension as reported in Table 14A was added over a period of 5 seconds. The amount of the 48% aqueous zeolite suspension is reported in cubic meters per ton ( $m^3/t$ ) and the equivalent gallon per sack (gal/sk) value. After addition of the aqueous zeolite suspension to the mixing fluid, the blender speed was maintained at 4000 RPM for a further 5 seconds before the cement mix was added. The blender speed was maintained at 4000 RPM until all of the cement mix was added to the blender, which was over about a 15 second period. The blender was then covered, and the blender speed was increased to 12,000 RPM for about 35 seconds.

[0128] Alternatively, the mixing fluid is maintained alone in the Waring blender prior to addition of the cement mix. According to this alternative, all of the cement mix is added to the mixing fluid in the Waring blender over a 15 second period, at 4000 RPM of the blender. The blender is then covered, and the blender speed increased to 12,000 RPM for about 35 seconds. The blender is then slowed to about 4000 RPM, and the amount of the 48% aqueous zeolite suspension is added. The blender speed is maintained at about 4000 RPM until a homogenous mix is achieved.

[0129] The column labeled "Zeolite Equivalent % dry basis" illustrates the amount of dry zeolite that is equivalent to the amount of zeolite in the composition, added as an aqueous zeolite suspension.

**Table 14A**

No.	Density kg/m <sup>3</sup> (lb/gal)	Dry Zeolite % bwob	48% Aq. Zeolite $m^3/t$ (gal/sk)	Zeolite Equivalent % dry basis	Water % bwob
1	1620 (13.5)	0	0.494 (5.55)	32	59.5
2	1620 (13.5)	0	0.762 (8.56)	50	48.8
3	1620 (13.5)	50	0	50	101.3
4	1620 (13.5)	0	1.016 (11.42)	67	38.7
5	1620 (13.5)	67	0	67	113.7

No.	Density kg/m <sup>3</sup> (lb/gal)	Dry Zeolite % bwob	48% Aq. Zeolite m <sup>3</sup> /t (gal/sk)	Zeolite Equivalent % dry basis	Water % bwob
6	1440 (12.0)	0	0.762 (8.56)	50	112.6
7	1440 (12.0)	50	0	50	166.7
8	1620 (13.5)	0	0.762 (8.56)	50	48.4**
9	1620 (13.5)	0	0.762 (8.56)	50	52.4*
10	1440 (12.0)	0	0.762 (8.56)	50	112.6
11	1440 (12.0)	0	1.016 (11.42)	67	113.0

\* seawater

\*\* With 0.07 gal/sk HR-6L brand commercial retarder as discussed above.

[0130] The viscosity (dial reading) of the cement compositions was measured using a Fann Model 35 viscometer, and reported in the Rheology Results in **Table 14B**. The viscosity was taken as the measurement of the dial reading on the Fann Model 35 at the different rotational speeds as indicated in 600 to 3 RPM, and at the temperature as indicated in **Table 14B**. For example, the Fann Viscometer is rotated at 300 RPM (revolutions per minute) for 60 seconds and a value on the dial is read, the speed is then changed to 200 RPM and the new value on the dial reading taken. There are a number of theoretical models known to those of ordinary skill in the art that can be used to convert the values from the dial readings at the different RPM's into viscosity (centipoises). In addition, different viscometer models use different RPM values, thus, in some instances, a measurement is not available at a particular RPM value.

[0131] The rheology data was obtained generally according to the procedures set forth in Section 12 of the API Specification RP 10B, 22<sup>nd</sup> Edition, 1997, of the American Petroleum Institute (the entire disclosure of which is hereby incorporated as if reproduced in its entirety). The aforementioned API procedures were modified in that the initial reading at 300 RPM was taken after 60 seconds of continuous rotation at that speed. Dial readings at 200, 100, 60, 30, 6 and 3 were then recorded in descending order at 20-second intervals. The final reading at 600 RPM was taken after 60 seconds of continuous rotation at that speed. The results of the rheology testing are reported below in Table 14B. The rheology results indicate that cement compositions prepared from cement mixes comprising an aqueous zeolite suspension have favorable mixability and thixotropic characteristics.

Table 14B

No.	Mix-ability	Rheology @ 49°C (120°F) (Fann 35 dial readings)							
		600 RPM	300 RPM	200 RPM	100 RPM	60 RPM	30 RPM	6 RPM	3 RPM
1	Good	65	51	44	37	34	30	21	14
2	Good	126	101	95	85	79	70	23	16
3	Good	150	132	116	105	97	87	31	22
4	Reasonable	210	169	152	121	90	78	35	24
5	Reasonable	225	205	187	164	146	120	44	34
6	Excellent	22	16	15	12	11	8	7	6
7	Excellent	33	24	20	16	14	12	8	5
8	Good	93	77	71	62	59	57	27	23
9	Good	67	53	46	37	32	27	11	7
10	Excellent	35	30	28	25	24	23	14	12
11	Excellent	49	38	35	30	27	25	12	10

[0132] Compressive strength and thickening time for those compositions comprising aqueous zeolite (nos. 1, 2, 4, 6 and 8 - 11) were tested. The temperature at which the compressive strength data was gathered was an arbitrarily chosen value based on typical values for bottom hole static temperature (BHST) of a well. Thickening time was tested by a Well Simulation Thickening Time test as set forth in API Specification 10B 22<sup>nd</sup> Edition, 1997, of the American Petroleum Institute, the entire disclosure of which is incorporated herein by reference. Compressive strength was tested by Non-Destructive Sonic Testing as set forth in API Specification 10B 22<sup>nd</sup> Edition, 1997, of the American Petroleum Institute, the entire disclosure of which is incorporated herein by reference. The test results are indicated in Table 14C, and illustrate the utility of using aqueous zeolite in cement compositions to achieve good compressive strengths and thickening times.

**Table 14C**

No.	Density kg/m <sup>3</sup> (lb/gal)	Zeolite m <sup>3</sup> /t (gal/sk)	Thickening time (Hr:min) 49°C (120°F)	Compressive strength MPa (psi) 66°C (150°F)			
				4 Hr	8 Hr	12 Hr	24 Hr
1	1620 (13.5)	0.494 (5.55)	3:40	1.45 (210)	4.42 (640)	10.45 (1515)	13.80 (2000)
2	1620 (13.5)	0.762 (8.56)	1:16	2.07 (300)	10.35 (1500)	14.95 (2166)	15.25 (2210)
4	1620 (13.5)	1.016 (11.42)	2:20	2.07 (300)	10.35 (1500)	15.11 (2190)	15.12 (2192)
6	1440 (12.0)	0.762 (8.56)	>15	0.41 (60)	2.07 (300)	4.18 (606)	5.80 (840)
8	1620 (13.5)	0.762 (8.56)	3:45	1.72 (250)	4.48 (650)	11.92 (1728)	14.88 (2157)
9	1620 (13.5)*	0.762 (8.56)	2:25	1.21 (175)	8.28 (1200)	12.41 (1798)	15.20 (2203)
10	1440 (12.0)	0.762 (8.56)	11:25	0.41 (60)	2.21 (320)	4.35 (631)	6.13 (888)
11	1440 (12.0)	1.016 (11.42)	>24	0.62 (90)	2.90 (420)	5.38 (779)	6.60 (956)

[0133] The temperature at which the compressive strength data was gathered and reported in Table 14C was 150°F BHST. **Table 14D** reports compressive strength and thickening time data gathered at 180°F BHST for compositions formed from components as listed in Table 14D. The compositions listed in Table 14D were prepared according to the procedures set forth in API Specification RP10B, 22nd edition, 1997, of the American Petroleum Institute, the entire disclosure of which is incorporated herein by reference. Generally, the API procedure used is as described above with respect to the compositions listed in Table 14A. Each cement composition was formed from a cement mix comprising a base blend comprising 100 weight percent Class G cement. The cement compositions were prepared by mixing each cement mix with a mixing fluid comprising water in the amount listed in Table 14D, which is reported as a percentage by weight of the base blend (% bwob) of each cement mix. For composition nos. 1 - 3, the mixing fluid further comprised HR-6L in the amount reported in Table 14D. HR-6L is the tradename for an aqueous solution of lignosulfonate, which is commercially available as a

retarder from Halliburton Energy Services. An amount of the 48% aqueous zeolite suspension as reported in Table 14D was added to the mixing fluid over a period of 5 seconds, in the manner as described above with respect to Table 14A. The amount of the 48% aqueous zeolite suspension is reported in cubic meters per ton ( $m^3/t$ ) and the equivalent gallon per sack (gal/sk) value.

[0134] As was the case with respect to the results reported in Table 14C, the compressive strength test temperature was an arbitrarily chosen value based on typical BHST values for a well. Thickening time was tested by the Well Simulation Thickening Time test as set forth in API Specification 10B 22<sup>nd</sup> Edition, 1997, and incorporated above. Compressive strength was tested by Non-Destructive Sonic Testing as set forth in API Specification 10B 22<sup>nd</sup> Edition, 1997, of the American Petroleum Institute, and incorporated above.

**TABLE 14D**

No	Density kg/m <sup>3</sup> (lb/gal)	Aq. Zeolite m <sup>3</sup> /t (gal/sk)	Zeolite Equiv. % dry basis	HR-6L m <sup>3</sup> /t (gal/sk)	Water % bwob	Thick. time Hr:min at 66C (150°F)	Compress. Strength at 82C (180°F) MPa (psi)			
							4 Hr	8 Hr	12 Hr	24 Hr
1	1620 (13.5)	0.762 (8.56)	50	0.018 (0.20)	47.6	2:15	0.69 (100)	10.4 (1500)	13.0 (1879)	14.3 (2076)
2	1620 (13.5)	0.762 (8.56)	50	0.027 (0.30)	47.1	2:57	0.69 (100)	7.59 (1100)	12.6 (1822)	14.5 (2095)
3	1620 (13.5)	0.762 (8.56)	50	0.031 (0.35)	46.8	3:25	0.69 (100)	11.7 (1700)	13.2 (1910)	15.2 (2202)
4	1620 (13.5)	0.762 (8.56)	50	0.00 (0.00)	48.8	1:16	2.41 (350)	10.4 (1500)	15.2 (2200)	15.2 (2200)

[0135] The compressive strength and thickening time results illustrate that cement compositions comprising aqueous zeolite are acceptable for oil well cementing practices.

[0136] One advantage of an embodiment using an aqueous zeolite suspension is that pumpable slurries are attainable with aqueous zeolite at high concentrations. Moreover, retardants (e.g., HR-6L) used with conventional compositions can be used with aqueous zeolite embodiments. In addition, seawater can be used as the mixing fluid, which makes this embodiment useful in conducting offshore operations. Aqueous zeolite suspensions further

provide for large quantities of zeolite to be incorporated into a cement composition, for example, up to 11.42 gal/sk (equivalent to 67% solid zeolite added to a dry blend).

[0137] Still another advantage of an embodiment comprising an aqueous zeolite suspension is that the zeolite remains suspended in water over time and does not settle out, thus a stock solution can be kept for long periods of time. Tables 14E – 14G illustrate the stability of various embodiments of aqueous zeolite suspensions.

[0138] First, five aqueous zeolite suspensions, each having a different zeolite activity percent, were prepared by adding BZM ZeoFume to water. “Active” refers to the weight percent zeolite of the aqueous zeolite suspension . Thus, Suspension No. 1, which was a 40% active zeolite suspension, was prepared by mixing 160 grams of the zeolite in 240 grams of water in a Waring blender at 4000 RPM for about 1 minute. Suspension No. 2 was a 45% active zeolite suspension that was prepared by mixing 180 grams of the zeolite in 220 grams of water in a Waring blender at 4000 RPM for about 1 minute. Suspension No. 3 was a 47.5% active zeolite suspension that was prepared by mixing 190 grams of the zeolite in 210 grams of water in a Waring blender at 4000 RPM for about 1 minute. Suspension No. 4 was a 48% active zeolite suspension that was prepared by mixing 192 grams of the zeolite in 208 grams of water in a Waring blender at 4000 RPM for about 1 minute. Suspension No. 5 was a 50% active zeolite suspension that was prepared by mixing 200 grams of the zeolite in 200 grams of water in a Waring blender at 4000 RPM for about 1 minute.

[0139] The stability of each of the five suspensions was then determined by sealing each suspension in a 100mL measuring cylinder, and measuring the amount of free water that collected over time. The free water data is indicated in Table 14E.

**Table 14E**

Susp. No.	Free Water (mL/100mL) at Time in Days									
	0 Days	0.17 Days	0.25 Days	0.75 Days	1.0 Days	2.25 Days	3.25 Days	4.0 Days	5.0 Days	7.25 Days
1 (40%)	0	8	11	16	20	20	20	20	20	20

2 (45%)	0	2	3	5	7	8	8.5	8.5	8.5	8.5
3 (47.5 %)	0	1	2	3	4.5	4.5	4.5	4.5	4.5	4.5
4 (48%)	0	1	2	2	3	3.5	3.5	3.5	3.5	3.5
5 (50%)	0	1	1.0	1.0	1.5	1.5	1.5	1.5	1.5	1.5

[0140] The viscosity (dial reading) of Suspension No. 4 (the 48 % active zeolite suspension) was measured using a Fann Model 35 viscometer, and reported in the rheology data in **Tables 14F and 14G**. The viscosity was taken as the measurement of the dial reading on the Fann Model 35 at the different rotational speeds as indicated in 600 to 3 RPM, and at the temperature as indicated in the tables. For example, the Fann Viscometer is rotated at 300 RPM (revolutions per minute) for 60 seconds and a value on the dial is read, the speed is then changed to 200 RPM and the new value on the dial reading taken. There are a number of theoretical models known to those of ordinary skill in the art that can be used to convert the values from the dial readings at the different RPM's into viscosity (centipoises). In addition, different viscometer models use different RPM values, thus, in some instances, a measurement is not available at a particular RPM value.

[0141] The rheology data was obtained generally according to the procedures set forth in Section 12 of the API Specification RP 10B, 22<sup>nd</sup> Edition, 1997, of the American Petroleum Institute (the entire disclosure of which is hereby incorporated as if reproduced in its entirety). The foregoing API procedure was modified in that the initial reading at 300 RPM was taken after 60 seconds continuous rotation at that speed. Dial readings at 200, 100, 60, 30, 6 and 3 were then recorded in descending order at 20-second intervals. The final reading at 600 RPM was taken after 60 seconds continuous rotation at that speed.

**Table 14F**

Time	Suspension No. 4 Rheology @ 27°C (80°F) (Fann 35 dial readings)							
	600 RPM	300 RPM	200 RPM	100 RPM	60 RPM	30 RPM	6 RPM	3 RPM
	0 min	131	84	67	50	43	39	35
30 min	115	76	60	42	35	31	28	24
1.0 Hr	132	80	63	45	37	31	27	23
2.0 Hr	129	78	61	44	36	30	28	24
3.0 Hr	131	80	62	43	35	30	28	25
24.0 Hr	154	92	71	50	41	35	20	28
5 Days	169	100	81	59	49	42	37	31

**Table 14G**

Time	Suspension No. 4 in Sealed Container Rheology @ 27°C (80°F) (Fann 35 dial readings)							
	600 RPM	300 RPM	200 RPM	100 RPM	60 RPM	30 RPM	6 RPM	3 RPM
	0 min	118	81	66	50	45	42	34
2 weeks	118	77	65	51	46	44	42	41

**[0142]** The rheology results reported in Table 14F indicate that the aqueous zeolite suspension remained stable over time, as there is no significant difference in rheology from initial mixing for up to three hours. When stored in a sealed container, the suspension remains stable for at least 2 weeks, as indicated by the stable rheology readings reported in Table 14G.

#### **Example 15**

**[0143]** Tables 15A and 15B illustrate the effectiveness of aqueous zeolite suspensions as a carrier for lightweight materials. The aqueous zeolite suspensions carrying lightweight materials are used to prepare lightweight cement compositions of desired densities.

**[0144]** In Example 15, the cement compositions were to be prepared from a cement mix comprising a base blend comprising 100 weight percent of a cementitious material as indicated in

Table 15A. Knowing that the base blend for each composition would comprise 100 weight percent of the indicated cementitious material, and knowing the desired density for the final cement composition, the aqueous zeolite suspensions were prepared first. It is understood, however, that the aqueous zeolite suspensions can be prepared last.

[0145] The amounts of water, zeolite, and lightweight materials used to form the aqueous zeolite were determined based on the desired density of the final cement composition, and the fact that the base blend of each cement composition comprised 100% cement. Thus, the amount of aqueous zeolite suspension used to form each cement composition can be expressed relative to the weight of the base blend, i.e., the 100 weight percent cement. For example, for Sample No. 1, the total weight percent of the components of the aqueous zeolite suspension amounts to 206 weight percent of the base blend. For Sample Nos. 2 and 3, the total weight percent of the components of the aqueous zeolite suspension amounts to 130 weight percent of the base blend.

[0146] Accordingly, three aqueous zeolite suspensions were prepared by mixing zeolite into water held in a Waring blender in the amounts as listed in Table 15A, where % bwob indicates a percentage of the weight of the base blend of each cement mix. The zeolite was mixed into the water at about 2000-4000 RPM, at a rate to produce a homogenized mix. The zeolite used was chabazite, which is commercially available from C2C Zeolite Corporation of Calgary, Canada.

[0147] The lightweight materials, which are Spherelite and S-38 3M Scotchlite beads for Sample No. 1, and Spherelite for Samples 2 and 3, were slowly added into the blender with the zeolite and the water in the amounts as listed in Table 15A, which is also reported as a percentage of the weight of the base blend (% bwob) of each cement mix. The lightweight materials were added to each blender at a variable rate between about 2000 RPM and about 4000 RPM until all of the lightweight materials had been added. When addition of the lightweight materials was complete, each of the aqueous zeolite suspensions was set aside for the preparation of the cement mixes.

[0148] Three cement mixes were prepared according to API Specification RP10B, 22<sup>nd</sup> edition, 1997, of the American Petroleum Institute, the entire disclosure of which is incorporated herein by reference. Generally, however, each cement mix comprised a base blend comprising the cementitious material listed in Table 15A, namely, 100 weight percent Class G cement for Sample No. 1, and 100 weight percent Class C cement for Sample Nos. 2 and 3.

[0149] The cement mix for sample nos. 2 and 3 further comprised the additives listed in Table 15A. The additives, namely the HR-5, CFR-2, Halad 344, and Halad 413 were dry-mixed with each base blend in the amounts as listed in Table 15A, where % bwob indicates a percentage based on the weight of the base blend. HR-5 is the tradename for a retarder comprising a refined lignosulfonate. CFR-2 is the tradename for a dispersant comprising sodium salt of naphthalene sulfonate condensed with formaldehyde. Halad 344 is the tradename for composition that comprises grafted polymers prepared by the polymerization of monomers or salts of monomers of N,N-dimethylacrylamide, 2-acrylamido-2-methylpropanesulfonic acid and acrylonitrile having a lignin or lignite or other backbone. Halad 413 is the tradename for a composition that comprises copolymers or salts of copolymers of N,N-dimethylacrylamide (NNDMA) and 2-acrylamido, 2-methyl propane sulfonic acid (AMPS). Each of HR-5, CFR-2, Halad 344 and Halad 413 are products commercially available from Halliburton Energy Services.

[0150] The base blend and the additives comprised the cement mix from which an initial cement composition was prepared. Three initial cement compositions were prepared by adding each cement mix to its own mixing fluid being maintained in a blender at 4000 RPM. For each of the initial cement compositions, the mixing fluid comprised water in the amount reported in Table 15A, where % bwob indicates a percentage based on the weight of the base blend. For Sample No. 1, the mixing fluid further comprised D-air 2, which is a polypropylene glycol commercially available from Halliburton Energy Services, Duncan, Oklahoma. D-air 2 was added to the mixing fluid in a percentage based on the weight of the base blend (% bwob) as listed in Table 15A. The cement mix temperature and mixing fluid temperature were both 24°C (75°F).

[0151] The cement mix was added to the mixing fluid over a 15 second period. A cover was then placed on the blender, and mixing was continued at about 12,000 RPM for about 35 seconds. The blender was then slowed to about 4000 RPM and aqueous zeolite suspension nos. 1, 2 and 3 were added to each of the initial cement composition nos. 1, 2 and 3, respectively. The blender speed was maintained at about 4000 RPM until the initial cement composition and the aqueous zeolite suspension were a homogeneous blend. Each homogeneous blend is referred to as the final cement composition.

[0152] Example 15 illustrates that a cement mix can be blended initially with enough water to result in an initial cement composition having the consistency of a fluid slurry. The initial cement composition is then blended with a liquid zeolite suspension to form a final cement composition. Thus, the total water requirement of a final cement composition is that of the water in the initial cement composition and the water in the aqueous zeolite suspension (which is also indicated in Table 15A). The density of the initial cement composition can be measured within the measurement limitations of a densitometer, and then the aqueous zeolite suspension carrying the lightweight materials can be metered in. By metering in the aqueous zeolite suspension, the density of the lightweight cement composition being formed can be controlled more accurately. In addition, the aqueous zeolite suspension holds the lightweight materials in a stable suspension, thus avoiding separation of the lightweight materials.

TABLE 15A

	Sample No. 1	Sample No. 2	Sample No. 3
<b>Aq. Zeolite Suspens. Components</b>			
Water (% bwob)	106	60	60
Zeolite (% bwob)	35	30	30
Spherelite (%bwob)	30	40	40
S-38 3M Scotchlite Beads (%bwob)	32	0	0
<b>Aq. Zeolite Suspens. Properties</b>			
Density	839 kg/m <sup>3</sup> (6.99 lb/gal)	1060 kg/m <sup>3</sup> (8.84 lb/gal)	1060 kg/m <sup>3</sup> (8.84 lb/gal)

	Sample No. 1	Sample No. 2	Sample No. 3
Total Fluid	1.06 m <sup>3</sup> /t (11.96 gal/sk)	0.59 m <sup>3</sup> /t (6.67 gal/sk)	0.59 m <sup>3</sup> /t (6.67 gal/sk)
Yield	2.43 m <sup>3</sup> /t (3.66 ft <sup>3</sup> /sk)	1.23 m <sup>3</sup> /t (1.85 ft <sup>3</sup> /sk)	1.23 m <sup>3</sup> /t (1.85 ft <sup>3</sup> /sk)
<b>Cement Mix Base Blend Components</b>			
Class G cement (wt %)	100	0	0
Class C cement (wt %)	0	100	100
<b>Cement Mix Additives</b>			
HR-5 (% bwob)	0.5	0	0
CFR-2 (% bwob)	0	0.3	0
Halad-344 (% bwob)	0	0	0.6
Halad-413 (% bwob)	0	0	1.00
<b>Mixing Fluid</b>			
Water (% bwob)	36.0	46.0	46.0
D-air 2 (% bwob)	0.5	0	0
<b>Initial Cement Composition Properties</b>			
Density	1952 kg/m <sup>3</sup> (16.27 lb/gal)	1885 kg/m <sup>3</sup> (15.71 lb/gal)	1879 kg/m <sup>3</sup> (15.66 lb/gal)
Water Requirement	0.36 m <sup>3</sup> /t (4.06 gal/sk)	0.46 m <sup>3</sup> /t (5.19 gal/sk)	0.46 m <sup>3</sup> /t (5.19 gal/sk)
Total Fluid	0.41 m <sup>3</sup> /t (4.56 gal/sk)	0.46 m <sup>3</sup> /t (5.19 gal/sk)	0.46 m <sup>3</sup> /t (5.19 gal/sk)
Yield	0.72 m <sup>3</sup> /t (1.09 ft <sup>3</sup> /sk)	0.78 m <sup>3</sup> /t (1.17 ft <sup>3</sup> /sk)	0.79 m <sup>3</sup> /t (1.19 ft <sup>3</sup> /sk)
<b>Final Cement Composition Properties (Initial Cement Comp. Blended with Aq. Zeolite Suspens.)</b>			
Density	1106 kg/m <sup>3</sup> (9.22 lb/gal)	1381 kg/m <sup>3</sup> (11.51 lb/gal)	1380 kg/m <sup>3</sup> (11.50 lb/gal)
Water Requirement	0.46 m <sup>3</sup> /t (5.19 gal/sk)	0.46 m <sup>3</sup> /t (5.19 gal/sk)	0.46 m <sup>3</sup> /t (5.19 gal/sk)

	Sample No. 1	Sample No. 2	Sample No. 3
Total Fluid	1.43 m <sup>3</sup> /t (16.05 gal/sk)	1.06 m <sup>3</sup> /t (11.96 gal/sk)	1.06 m <sup>3</sup> /t (11.96 gal/sk)
Yield	3.07 m <sup>3</sup> /t (4.63 ft <sup>3</sup> /sk)	2.00 m <sup>3</sup> /t (3.02 ft <sup>3</sup> /sk)	2.01 m <sup>3</sup> /t (3.03 ft <sup>3</sup> /sk)

[0153] Rheology, compressive strength, thickening time, free water, and settling data were tested for each of the aqueous zeolite suspensions, initial cement compositions, and the final cement compositions. The data is as listed in **Table 15B**.

[0154] The viscosity (dial reading) of the cement compositions was measured using a Fann Model 35 viscometer, and reported in the rheology results in Table 15B. The viscosity was taken as the measurement of the dial reading on the Fann Model 35 at the different rotational speeds as indicated in 600 to 3 RPM, and at the temperature as indicated in Table 15B. For example, the Fann Viscometer is rotated at 300 RPM (revolutions per minute) for 60 seconds and a value on the dial is read, the speed is then changed to 200 RPM and the new value on the dial reading taken. There are a number of theoretical models known to those of ordinary skill in the art that can be used to convert the values from the dial readings at the different RPM's into viscosity (centipoises). In addition, different viscometer models use different RPM values, thus, in some instances, a measurement is not available at a particular RPM value.

[0155] Rheology was tested according to the procedures set forth in Section 12 of the API Specification RP 10B, 22<sup>nd</sup> Edition, 1997, of the American Petroleum Institute (the entire disclosure of which is hereby incorporated as if reproduced in its entirety). The foregoing API procedure was modified in that the initial reading at 300 RPM was taken after 60 seconds continuous rotation at that speed. Dial readings at 200, 100, 60, 30, 6 and 3 were then recorded in descending order at 20-second intervals. The final reading at 600 RPM was taken after 60 seconds continuous rotation at that speed.

[0156] With respect to the Initial Cement Properties and the Final Cement Properties, free water data was gathered according to Section 15.5 of Addendum 2 of the API Specification

10B 22<sup>nd</sup> Edition, 1997, of the American Petroleum Institute, the entire disclosure of which is hereby incorporated herein by reference. The slurry was first conditioned in an atmospheric consistometer for 30 minutes. Generally according to said API Specification, 250 ml of each sample was then poured into its own 250 ml graduated glass cylinder. Each sample was stirred with a spatula during pouring, and then sealed with a plastic film wrap to prevent evaporation. A two hour test period was then initiated. During this two hour test period, the graduated cylinders were left standing. After two hours, the free fluid that had gathered on top of each sample inside the cylinder was measured.

[0157] With respect to the Aqueous Zeolite Suspension Properties, the free fluid data was gathered by pouring 250 mL of each of the aqueous zeolite suspensions directly into a 250 mL graduated glass cylinder. Each sample was stirred with a spatula during pouring, and then sealed with a plastic film wrap to prevent evaporation. A two hour test period was then initiated. During this two hour test period, the graduated cylinders were left standing. After two hours, the free fluid that had gathered on top of each sample inside the cylinder was measured.

[0158] The volume of free fluid formed in each of the above-described tests is reported in Table 15B, and provides an indication of settling, where a zero percent value indicates no settling. Settling data is based on observation of the degree of sample settling in the free water tests.

TABLE 15B

Aq. Zeolite Suspens. Properties	Dial Reading @ 27°C (80°F)						Compress. Strength @ 66°C (150°F) MPa (psi)	Thickening Time @ 57°C (134°F) (Hr:min)	Free water (mL/250mL)	Settling
	600 RPM	300 RPM	200 RPM	100 RPM	6 RPM	3 RPM				
Sample No. 1	229	125	90	56	19	16	n/a	n/a	0	none
Sample No. 2	206	86	53	39	17	15	n/a	n/a	0	none
Sample No. 3	255	180	135	88	37	33	n/a	n/a	0	none

	Dial Reading @ 27°C (80°F)						Compress. Strength @ 66°C (150°F) MPa (psi)	Thickening Time @ 57°C (134°F) (Hr:min)	Free water (mL/250mL)	Settling
	600 RPM	300 RPM	200 RPM	100 RPM	6 RPM	3 RPM				
<b>Initial Cement Comp. Properties</b>										
Sample No. 1	165	45	33	22	10	9	n/a	n/a	0	none
Sample No. 2	245	180	174	165	61	45	n/a	n/a	0	none
Sample No. 3	300+	300+	300+	184	29	23	n/a	n/a	0	none
<b>Final Cement Comp. Properties</b>										
Sample No. 1	--	96	71	43	12	10	7.94 (1151)	3:34	0	none
Sample No. 2	150	104	86	67	33	24	14.99 (2172)	1.14	0	none
Sample No. 3	--	260	188	107	10	5	20.87 (3025)	0:51	0	none

[0159] The data in Table 15B illustrates that cement compositions blended with aqueous suspensions comprising zeolite and lightweight materials possess favorable rheological properties, good compressive strength, and good thickening time. The lack of settling and the free water data indicate that there is no segregation of the lighter weight materials.

#### Example 16

[0160] **Table 16** illustrates yet another embodiment of the cement compositions of the present invention, where zeolite is incorporated into a cement mix from which a foam cement composition is formed. The zeolite acts as a foam cement-stability agent.

[0161] A conventional foamed cement composition (Cement Composition No. 1) was prepared from a cement mix comprising a base blend comprising 56 weight percent Class G cement, 22 weight percent fly ash, and 22 weight percent fumed silica. The components of the base blend of the cement mix were dry-mixed by hand in a glass jar. The fly ash was Class F fly

ash, which is commercially available from Halliburton Energy Services. Fumed silica is commercially available from Fritz Industries, Mesquite, Texas, USA.

[0162] An unfoamed cement composition was formed by adding the cement mix to a mixing fluid comprising water being maintained in a blender at 4000 RPM. The cement mix was added to the mixing fluid over a 15 second period. When all of the cement mix was added to the mixing fluid, a cover was placed on the blender and mixing was continued at about 12,000 RPM for about 35 seconds. The amount of water required in the blender is listed in Table 16 in % bwob, which represents a percentage based on total weight of the base blend. The dry-mix temperature and mixing fluid temperature were both 24°C (75°F).

[0163] For the preparation of Cement Comp. No. 2, an aqueous zeolite suspension was prepared that contained 48 weight percent zeolite. The method used to prepare the aqueous zeolite suspension was to add 7.2 kg of zeolite to 7.8 kg of water in a 5 gallon bucket, and stir with a variable speed Premier Mill Corp. laboratory dispersator mixer at low speed until a homogenous suspension was obtained. Chabazite, which is commercially available from C2C Zeolite Corporation of Calgary, Canada, was used as the zeolite. The aqueous zeolite suspension was then set aside for preparation of the base blend of the cement mix from which Cement Composition No. 2 was formed.

[0164] Cement Composition No. 2 was prepared from a cement mix comprising a base blend comprising 100 weight percent Class G cement, as reported in Table 16. Hydrated lime was dry-mixed with the base blend in the amount reported in Table 16, which is a percentage by weight of the base blend. Hydrated lime is a conventional additive for increasing the final strength of the cement composition. The Class G cement and the hydrated lime comprised the cement mix for composition No. 2.

[0165] After preparation of the cement mix, aqueous zeolite suspension in the amount reported in Table 16 was added to 293% bwob water in a blender and mixed at 4000 RPM for 1 minute. The 293% bwob water reported in Table 16 indicates a percentage based on the weight of the base blend of the cement mix. The aqueous zeolite suspension added to the water was the

48% suspension previously prepared and set aside. After blending of the water and the aqueous zeolite suspension, an unfoamed cement composition was prepared by adding the cement mix to the blender at 4000 RPM over about a 15 second period. The blender was then covered, and the blender speed was increased to 12,000 RPM for about 35 seconds.

[0166] Alternatively, water alone is maintained in the Waring blender prior to addition of the cement mix. According to this embodiment, the cement mix is added to water in the Waring blender over a 15 second period, at 4000 RPM of the blender. The blender is then covered, and the blender speed increased to 12,000 RPM for about 35 seconds. The blender is then slowed to about 4000 RPM, and the aqueous zeolite suspension is added. The blender speed is maintained at about 4000 RPM until a homogenous mix is achieved.

[0167] To generate a foamed cement composition from each of the above-described unfoamed cement compositions, the following procedure was followed. A 2-quart multiblade foam blender was assembled from the following components: a sealed mix container commercially available from Fann Instruments; blades commercially available Waring Laboratory Products; and a stand-off kit (extension rods) commercially available from Fann Instruments. Assembly of a multi-blade foam blender comprises modifying a standard mixing assembly similar to that of a conventional Waring blender. A extension rod is screwed on the mixing assembly, then a Waring blender blade is placed onto the extension rod. Another extension rod is then screwed on above the blade and the process repeated to give a multiblade paddle having 4 extension rods and 5 sets of waring blender blade. A top spindle is placed on the top waring blender blade and this connects to a brushing in the lid of the multiblade foam blender to seal the unit.

[0168] About half of the unfoamed composition was added to the 2-quart multiblade foam blender. A foam additive comprising an ethoxylated alcohol ether sulfate surfactant, which is commercially available from Halliburton Energy Services under the tradename Zonesealant 2000, was then added to the blender in the amount as indicated in Table 16, where % bvow is a percent by volume of total water present in the unfoamed cement composition.

[0169] After addition of the foam additive, the remainder of the unfoamed composition was added to the blender, and the blender was shaken about three to five times. The foam in the blender was sheared at the maximum speed of 12,000 RPM for about 15 seconds, at which point the final foam density was obtained. Alternatively, if the multiblade foam blender has an audible blender speed change feature to indicate when the blender is full, shearing continues until the audible indication is given, at which point the final foam density is obtained.

[0170] The final foam density, foam quality measurement, and sedimentation data for each composition is as indicated in Table 16.

TABLE 16

	Cement Composition No. 1	Cement Composition No. 2
<b>Cement Mix Base Blend Composition</b>		
Class G Cement (wt. %)	56	100
Class F Fly Ash (wt. %)	22	0
Fumed Silica (wt. %)	22	0
<b>Cement Mix Additives</b>		
Hydrated Lime (% bwob)	0	10
<b>Mixing Fluid</b>		
Water (% bwob)	208	293
<b>Aqueous Zeolite Suspension</b>	0	182.44% bwob (62.27% bwow)
<b>Properties of Unfoamed Composition</b>	1260 kg/m <sup>3</sup> (10.5 lb/gal)	1260 kg/m <sup>3</sup> (10.5 lb/gal)
<b>Properties of Foamed Composition</b>		
Foam additive (% bwow) (Zonesealant 2000)	2	2
Density	960 kg/m <sup>3</sup> (8 lb/gal)	960 kg/m <sup>3</sup> (8 lb/gal)
Foam quality	23.9%	24.1%
<b>Sedimentation Tests</b>		
Density of Top	0 kg/m <sup>3</sup> (0 lb/gal)	863 kg/m <sup>3</sup> (7.19 lb/gal)
Density of Middle	1144 kg/m <sup>3</sup> (9.54 lb/gal)	871 kg/m <sup>3</sup> (7.26 lb/gal)

	Cement Composition No. 1	Cement Composition No. 2
Density of Bottom	1221 kg/m <sup>3</sup> (10.18 lb/gal)	871 kg/m <sup>3</sup> (7.26 lb/gal)

[0171] The foam quality measurement is based on the amount of foam (air) required to decrease the density from that of the unfoamed cement composition (10.5 lb/gal) to that of the foamed cement composition (8 lb/gal), and is given as the percent of air by the total volume of the foamed composition.

[0172] Sedimentation data was gathered by allowing each composition to cure in a 4 by 2 inch plastic container at 49°C(120°F) for 48 hours. The cured compositions were then cut into three equal sections, top, middle and bottom. To determine the density of each section, the procedures set forth in Section 15.6.5 of API Specification RP 10B, 22<sup>nd</sup> Edition, 1997, of the American Petroleum Institute (the entire disclosure of which is hereby incorporated as if reproduced in its entirety) were followed. Generally, however, a 1000 mL beaker containing 700 mL of water was placed on a balance and tared to zero.

[0173] A noose of thin line was placed around the section to be measured, and the section was suspended by the line into the water in the beaker. The sample was suspended into the water so that it was totally immersed in the water, but was not touching the bottom or sides of the beaker, nor did it have air bubbles clinging to it. With the section thus suspended in the water, the weight indicated on the balance was recorded. The section was then lowered so that the section rested completely on the bottom of the beaker and weight indicated on the balance recorded. The section was then removed and the balance re-tared to zero. These procedures were then repeated for each section.

[0174] The density of each section was calculated by dividing the weight recorded when the section was placed on the bottom of the beaker by the weight recorded when the section was suspended in the water in the beaker and multiplying by 8.34.

[0175] The foam quality and sedimentation values listed in Table 16 illustrate that zeolite is an effective foam-cement stability agent.

**Example 17**

[0176] Table 17 illustrates the incorporation of zeolite into the base system, which enables the use of a lower foam quality (less air per volume of base system) to produce lower density foamed cement.

[0177] Two conventional foamed cement compositions (Comp. Nos. 1 and 3) were prepared from a cement mix comprising a base blend comprising 100 weight percent Class G cement, as reported in Table 17. Bentonite as an additive was dry-mixed with the base blend by hand in a glass jar. The amount of bentonite mixed with each base blend is reported in Table 17 as a percentage based on weight of the base blend.

[0178] The base blend and the additive comprised the cement mix from which each unfoamed cement composition reported in Table 17 was prepared. An unfoamed cement composition was prepared from each cement mix by adding the cement mix to a mixing fluid comprising water being maintained in a blender at 4000 RPM. The cement mix was added to the mixing fluid over a 15 second period. When all of the cement mix was added to the mixing fluid, a cover was placed on the blender and mixing was continued at about 12,000 RPM for about 35 seconds. The amount of water required in the blender is listed in Table 17 in % bwob, which represents a percentage based on total weight of the base blend. The cement mix temperature and mixing fluid temperature were both 24°C (75°F).

[0179] An unfoamed cement composition for Composition No. 2 was prepared from a cement mix comprising a base blend comprising Class G cement and zeolite in the amounts (weight percents) reported in Table 17. The cement and the zeolite were dry-mixed by hand in a glass jar. Chabazite, which is commercially available from C2C Zeolite Corporation of Calgary, Canada, was used as the zeolite. An unfoamed cement composition was prepared from the cement mix by adding the cement mix over a 15 second period to a mixing fluid comprising water being maintained in a blender at 4000 RPM. When addition of the cement mix was complete, a cover was placed on the blender and mixing was continued at about 12,000 RPM for about 35 seconds. The amount of water required in the blender is listed in Table 17 in % bwob,

which represents a percentage based on total weight of the base blend. The cement mix temperature and mixing fluid temperature were both 24°C (75°F).

[0180] For the preparation of Comp. No. 4, an aqueous zeolite suspension was prepared that contained 48 weight percent zeolite. The method used to prepare the aqueous zeolite suspension was to add 7.2 kg of zeolite to 7.8 kg of water in a 5 gallon bucket, and stir with a variable speed Premier Mill Corp. laboratory dispersator mixer at low speed until a homogeneous suspension was obtained. Chabazite, which is commercially available from C2C Zeolite Corporation of Calgary, Canada, was used as the zeolite. The aqueous zeolite suspension was then set aside for preparation of the base blend of the cement mix from which Comp. No. 4 was formed.

[0181] Cement Composition No. 4 was prepared from a cement mix comprising a base blend comprising 100 weight percent Class G cement as reported in Table 17. After preparation of the cement mix, 182.4% bwob of the aqueous zeolite suspension was added to 106% bwob water in a blender and mixed at 4000 RPM for 1 minute. The % bwob reported in Table 17 for both the water and the aqueous zeolite suspension indicates a percentage based on the weight of the base blend of the cement mix. The aqueous zeolite suspension added to the water was the 48% suspension previously prepared and set aside. After blending of the water and the aqueous zeolite suspension, an unfoamed cement composition was prepared by adding the cement mix to the blender at 4000 RPM over about a 15 second period. The blender was then covered, and the blender speed was increased to 12,000 RPM for about 35 seconds.

[0182] Alternatively, water alone is maintained in the Waring blender prior to addition of the cement mix. According to this embodiment, the cement mix is added to water in the Waring blender over a 15 second period, at 4000 RPM of the blender. The blender is then covered, and the blender speed increased to 12,000 RPM for about 35 seconds. The blender is then slowed to about 4000 RPM, and the aqueous zeolite suspension is added. The blender speed is maintained at about 4000 RPM until a homogenous mix is achieved.

[0183] To generate a foamed cement composition from each of the above-described unfoamed cement compositions, the following procedure was followed. A 2-quart multiblade foam blender was assembled from the following components: a sealed mix container commercially available from Fann Instruments; blades commercially available Waring Laboratory Products; and a stand-off kit (extension rods) commercially available from Fann Instruments. Assembly of a multi-blade foam blender comprises modifying a standard mixing assembly similar to that of a conventional Waring blender. A extension rod is screwed on the mixing assembly, then a Waring blender blade is placed onto the extension rod. Another extension rod is then screwed on above the blade and the process repeated to give a multiblade paddle having 4 extension rods and 5 sets of waring blender blade. A top spindle is placed on the top waring blender blade and this connects to a brushing in the lid of the multiblade foam blender to seal the unit.

[0184] About half of the unfoamed composition was added to the 2-quart multiblade foam blender. A foam additive comprising an ethoxylated alcohol ether sulfate surfactant, which is commercially available from Halliburton Energy Services under the tradename Zonesealant 2000, was then added to the blender in the amount as indicated in Table 17, where % bvow is a percent by volume of total water present in the unfoamed cement composition.

[0185] After addition of the foam additive, the remainder of the unfoamed composition was added to the blender, and the blender was shaken about three to five times. The foam in the blender was sheared at the maximum speed of 12,000 RPM for about 15 seconds, at which point the final foam density was obtained. Alternatively, if the multiblade foam blender has an audible blender speed change feature to indicate when the blender is full, shearing continues until the audible indication is given, at which point the final foam density is obtained.

[0186] The final foam density, foam quality measurement, and compressive strength data for each foamed cement composition is as indicated in Table 17.

TABLE 17

	Comp. No. 1	Comp. No. 2	Comp. No. 3	Comp. No. 4
Cement Mix Base Blend				

	<b>Comp. No. 1</b>	<b>Comp. No. 2</b>	<b>Comp. No. 3</b>	<b>Comp. No. 4</b>
<b>Components</b>				
Class G cement ( wt. %)	100	70	100	100
Zeolite (wt. %)	0	30	0	0
<b>Cement Mix Additives</b>				
Bentonite (% bwob)	4	0	8	0
<b>Mixing Fluid</b>				
Water (% bwob)	72	62	95	106
Aqueous Zeolite (% bwob)	0	0	0	182.4
<b>Density of Unfoamed Composition kg/m<sup>3</sup> (lb/gal)</b>	1680 (14)	1680 (14)	1560 (13)	1440 (12)
Foam additive (% bvow) (Zone Sealant 2000)	2	2	2	2
<b>Properties of Foamed Composition</b>				
Density kg/m <sup>3</sup> (lb/gal)	1200 (10.0)	1200 (10.0)	1200 (10.0)	1200 (10.0)
Foam Quality (%)	28.2	28.3	23.5	16.0
Compressive Strength at 49°C (120 °F) and 24 Hr	2.28 MPa (330 psi)	3.11 MPa (450 psi)	1.01 MPa (146 psi)	1.07 MPa (155 psi)
Compressive Strength at 49°C (120 °F) and 48 Hr	3.60 MPa (522 psi)	7.45 MPa (1078 psi)	1.84 MPa (268 psi)	2.54 MPa (368 psi)

[0187] The foam quality measurement is based on the amount of foam (air) required to decrease the density from that of the unfoamed cement composition to that of the foamed cement composition (10 lb/gal), and is given as the percent of air by the total volume of the foamed composition.

[0188] The compressive strength data was determined according to Non-Destructive Sonic Testing as set forth in API Specification 10B 22<sup>nd</sup> Edition, 1997, of the American Petroleum Institute, the entire disclosure of which is hereby incorporated herein by reference.

[0189] The foam quality and compressive strength data indicated in Table 17 illustrate that zeolite, in both a dry and an aqueous embodiment, is useful in the preparation of lightweight density foamed cement compositions with a lower foam quality and good compressive strength.

**Example 18**

[0190] According to another embodiment, zeolite is incorporated into a cement composition comprising micronized cement. The term "micronized cement" as used herein means a cement consisting of discrete particles having a particle size of not greater than about 30 microns. Preferably, the micronized cement is a Portland cement. Cement compositions made from cement mixes comprising micronized cement and zeolite possess good compressive strength and rheological properties.

[0191] Thirty cement compositions, each having a density as reported in Tables 18A and 18B were prepared according to API Specification RP 10B, 22<sup>nd</sup> Edition, 1997, of the American Petroleum Institute (the entire disclosure of which is hereby incorporated as if reproduced in its entirety). Following said API specification, a cement mix comprised of a base blend comprising Class C cement, MicroMatrix brand micronized Portland cement, and zeolite was formed by dry-mixing the cements and the zeolite in the amounts reported in the tables by hand in a glass jar. The cement mix additives, i.e., the sodium sulfate and cementing additive, were also dry-mixed with the base blend in the glass jar in the amounts reported in Tables 18A and 18B. The sodium sulfate and cementing additive amounts are reported as percentages of the weight of the base blend (% bwob) of each cement mix.

[0192] The zeolite used was clinoptilolite, which is commercially available from C2C Zeolite Corporation of Calgary, Canada. MicroMatrix brand cement is commercially available from Halliburton Energy Services, Duncan Oklahoma. The cementing additive is commercially available from Halliburton Energy Services as FDP-C661-VA, and comprises sodium sulfate, sodium carbonate, and other trace minerals. As indicated in Tables 18A and 18B, the cement mix for composition No. 8 further comprised Spherelite, which was dry-mixed therewith in the indicated amount based on the weight of the base blend. The cement mix for composition Nos.

1-3 and 18 further comprised Econolite, which was dry-mixed therewith in the indicated amount based on the weight of the base blend. Spherelite and Econolite are tradenames for lightweight materials commercially available from Halliburton Energy Services.

[0193] Each cement mix comprised the base blend and the additives as reported in Tables 18A and 18B. A cement composition was prepared from the cement mix by adding the cement mix to mixing fluid being maintained in a blender at 4000 RPM. All of the cement mix was added to the mixing fluid over a 15 second period. A cover was then placed on the blender, and mixing was continued at about 12,000 RPM for about 35 seconds. For each of the cement compositions, the mixing fluid was water in the amount reported in Tables 18A and 18B, where % bwob indicates a percentage based on total weight of the base blend of the cement mix. The cement mix temperature and mixing fluid temperature were both 24°C (75°F).

**TABLE 18A**

	No. 1	No. 2	No. 3	No. 4	No. 5	No. 6	No. 7	No. 8	No. 9	No. 10	No. 11
<b>Cement Mix Base Blend</b>											
Class C Cement (wt. %)	60	60	60	60	57	57	57	57	57	57	57
Micronized Portland Cement (wt. %) (MicroMatrix)	0	0	0	0	3	3	3	3	3	3	3
Zeolite (wt. %)	40	40	40	40	40	40	40	40	40	40	40
<b>Cement Mix Additives</b>											
Sodium sulfate (% bwob)	6	6	6	8	8	10	10	8	10	8	8

	No. 1	No. 2	No. 3	No. 4	No. 5	No. 6	No. 7	No. 8	No. 9	No. 10	No. 11
Cementing Additive (% bwob) (FDP-C661-VA)	2	2	2	2	2	0	2	1	2	0	1
Econolite (% bwob)	2	2	2	0	0	0	0	0	0	0	0
Spherelite (% bwob)	0	0	0	0	0	0	0	9	0	0	0
<b>Mixing Fluid</b>											
Water (% bwob)	197.6	179.23	163.76	164.11	197.40	197.53	200.83	166.68	182.47	161.16	162.52
<b>Density kg/m<sup>3</sup> (lb/gal)</b>	1300 (10.8)	1325 (11.0)	1350 (11.0)	1350 (11.2)	1300 (10.8)	1300 (10.8)	1300 (10.8)	1308 (10.7)	1325 (11.0)	1350 (11.2)	1350 (11.2)

**TABLE 18B**

	No. 12	No. 13	No. 14	No. 15	No. 16	No. 17	No. 18	No. 19	No. 20	No. 21
<b>Cement Mix Base Blend</b>										
Class C Cement (%)	55	55	55	55	55	60	60	60	60	57
Micronized Portland Cement (%) (MicroMatrix)	5	5	5	5	5	0	0	0	3	3
Zeolite (%)	40	40	40	40	40	40	40	40	37	40
<b>Cement Mix Additives</b>										
Sodium sulfate (% bwob)	0	8	8	8	8	6	6	6	8	8

	No. 12	No. 13	No. 14	No. 15	No. 16	No. 17	No. 18	No. 19	No. 20	No. 21
Cementing Additive (% bwob) (FDP-C661-VA)	0	0	0	1	2	0	1	0	0	1
Econolite (% bwob)	0	0	0	0	0	0	1	0	0	0
Spherelite (% bwob)	0	0	0	0	0	0	0	0	0	0
<b>Mixing Fluid</b>										
Water (% bwob)	149.66	161.0	161.0	162.37	163.73	190.93	194.10	158.5	195.1	195.6
<b>Density kg/m<sup>3</sup> (lb/gal)</b>	1350 (11.2)	1350 (11.2)	1350 (11.2)	1350 (11.2)	1300 (10.8)	1350 (11.2)	1300 (10.8)	1350 (11.2)	1300 (10.8)	1350 (11.2)

TABLE 18C

	No. 22	No. 23	No. 24	No. 25	No. 26	No. 27	No. 28	No. 29	No. 30
<b>Cement Mix Base Blend</b>									
Class C Cement (%)	55	48	45	60	57	54	51	60	60
Micronized Portland Cement (%) (MicroMatrix)	5	12	15	6	3	6	9	3	6
Zeolite (%)	40	40	40	34	40	40	40	37	34
<b>Cement Mix Additives</b>									
Sodium sulfate (% bwob)	8	8	8	8	8	8	8	8	8

	No. 22	No. 23	No. 24	No. 25	No. 26	No. 27	No. 28	No. 29	No. 30
Cementing Additive (% bwob) (FDP-C661-VA)	1	0	0	0	0	0	0	1	1
Econolite (% bwob)	0	0	0	0	0	0	0	0	0
Spherelite (% bwob)	0	0	0	0	0	0	0	0	0
<b>Mixing Fluid</b>									
Water	195.33	195.09	194.83	197.89	195.86	195.61	195.35	196.68	199.56
<b>Density kg/m<sup>3</sup> (lb/gal)</b>	1350 (11.2)	1300 (10.8)							

**[0194]** The results of compressive strength testing performed on composition nos. 1 – 30 are listed in Table 18D. The compressive strength was determined by Non-Destructive Sonic Testing as set forth in API Specification 10B 22<sup>nd</sup> Edition, 1997, of the American Petroleum Institute, the entire disclosure of which is hereby incorporated herein by reference. The test temperature (Test Temp) is reported in a “number/number” format because the test samples of the cement compositions were conditioned in an atmospheric consistometer for 90 minutes at 50° C, then allowed to cool to 30° C in an Ultrasonic Cement Analyzer (UCA). The samples were then cured in the UCA at 30° C for the duration of the compressive strength testing.

Table 18C

No.	COMPRESSIVE STRENGTH						
	Test Temp °C (°F)	Time to 0.35 MPa (50 psi) (Hr:Min)	Time to 3.5 MPa (500 psi) (Hr:Min)	Final Strength MPa (psi)	Time to Final Strength (Hr:Min)	Strength @ 48 hours MPa (psi)	
1	50/30 (122/86)	9:12	---	3.20 (464)	166:45	2.03 (294)	
2	50/30 (122/86)	9:01	---	2.89 (419)	166.30	2.10 (304)	
3	50/30 (122/86)	8:49	---	3.38 (490)	166:04	2.14 (310)	

No.	COMPRESSIVE STRENGTH					
	Test Temp °C (°F)	Time to 0.35 MPa (50 psi) (Hr:Min)	Time to 3.5 MPa (500 psi) (Hr:Min)	Final Strength MPa (psi)	Time to Final Strength (Hr:Min)	Strength @ 48 hours MPa (psi)
4	50/30 (122/86)	9:42	70:11	4.36 (632)	138:46	2.55 (370)
5	50/30 (122/86)	4:22	---	3.02 (438)	88.07	1.83 (265)
6	50/30 (122/86)	16:24	---	2.48 (359)	66:58	1.66 (241)
7	50/30 (122/86)	9:18	---	3.19 (462)	66:22	2.62 (380)
8	50/30 (122/86)	7:27	42:01	4.75 (688)	114:51	3.86 (559)
9	50/30 (122/86)	8:38	52:40	4.40 (638)	116:37	3.10 (449)
10	50/30 (122/86)	6:32	43:14	5.02 (728)	88:40	3.73 (541)
11	50/30 (122/86)	5:09	37:53	5.85 (848)	92:19	4.28 (620)
12	50/30 (122/86)	---	---	0.25 (36)	45:25	---
13	25 (77)	12:57	---	3.36 (487)	88:40	2.42 (351)
14	50/30 (122/86)	5:17	39:53	4.02 (583)	46:12	~4.14 (600)
15	50/30 (122/86)	8:01	66:15	4.23 (613)	91:49	2.42 (351)
16	50/30 (122/86)	4:45	37:16	4.94 (716)	138:47	4.14 (600)
20	50/30 (122/86)	---	---	0.22 (32)	18:00	---
24	50/30 (122/86)	10:55	---	1.06 (154)	21.08	---
25	50/30 (122/86)	16:31	---	0.40 (58)	16:31	---
26	50/30 (122/86)	12:54	---	2.40 (348)	105:31	1.73 (251)
27	50/30 (122/86)	14:28	---	0.52 (75)	19:42	---
28	50/30 (122/86)	14:28	---	1.05 (152)	34:22	---
29	50/30 (122/86)	11:15	---	3.20 (464)	90:04	1.90 (275)
30	50/30 (122/86)	4:22	---	3.25 (471)	89:48	1.93 (280)

[0195] **Table 18D** illustrates that cement compositions comprising zeolite and micronized cement (e.g., Nos. 29-30) reach a designated MPa value in lesser amounts of time and achieved higher final strengths in less time as compared to cement compositions that do not comprise micronized cement (e.g., Nos. 1-3).

[0196] The results of free water testing performed on composition Nos. 17 - 25 are listed in **Table 18E**. Free water data was gathered according to Section 15.5 of Addendum 2 of the API Specification 10B 22<sup>nd</sup> Edition, 1997, of the American Petroleum Institute, the entire disclosure of which is hereby incorporated herein by reference. Generally according to said API Specification, 250 ml of each cement composition was poured into its own 250 ml graduated

glass cylinder. Each cement composition was stirred with a spatula during pouring, and then sealed with a plastic film wrap to prevent evaporation. A two hour test period was then initiated. During this two hour test period, the graduated cylinders were left standing so that the cement compositions in the cylinders underwent static curing. After two hours, the free fluid that had gathered on top of each cement composition inside the cylinder was measured. The percent of free fluid was calculated as the measured milliliters of free fluid multiplied by 100 and then divided by the 250 milliliters of the initial cement composition.

**Table 18E**

	No. 17	No. 18	No. 19	No. 20	No. 21	No. 22	No. 23	No. 24	No. 25
Test Temp °C (°F)	20 (68)	20 (68)	20 (68)	20 (68)	20 (68)	20 (68)	20 (68)	20 (68)	20 (68)
% Free Water	16	0.12	2.4	<0.1	<0.1	<0.1	0	0	0

**[0197]** **Table 18E** illustrates that cement compositions comprising zeolite and micronized cement (e.g., Nos. 20 - 25) develop lesser amounts of free water as compared to cement compositions that do not comprise micronized cement (e.g., Nos. 17 - 19).

**[0198]** Although only a few exemplary embodiments of this invention have been described in detail above, those skilled in the art will readily appreciate that many other modifications are possible in the exemplary embodiments without materially departing from the novel teachings and advantages of this invention. Accordingly, all such modifications are intended to be included within the scope of this invention as defined in the following claims.